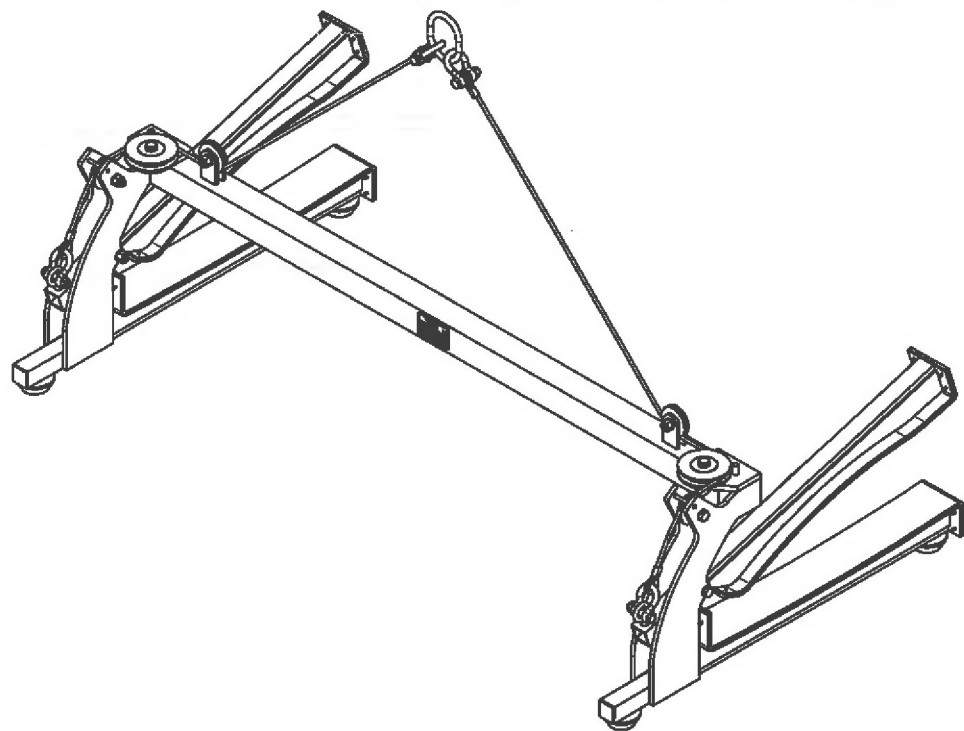
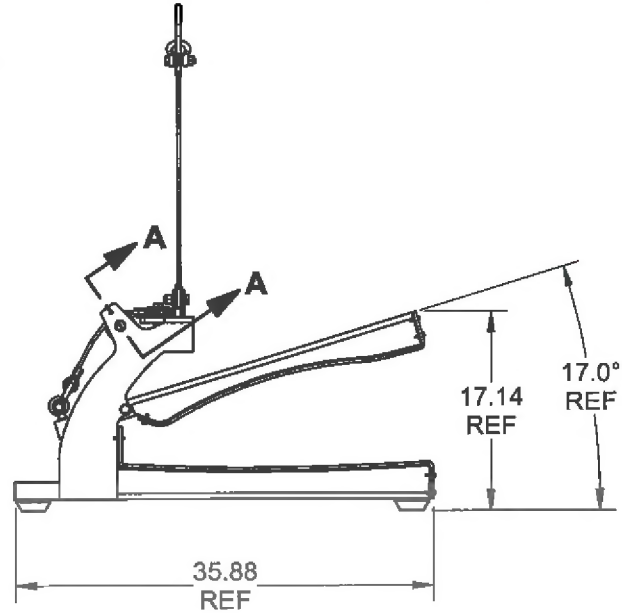


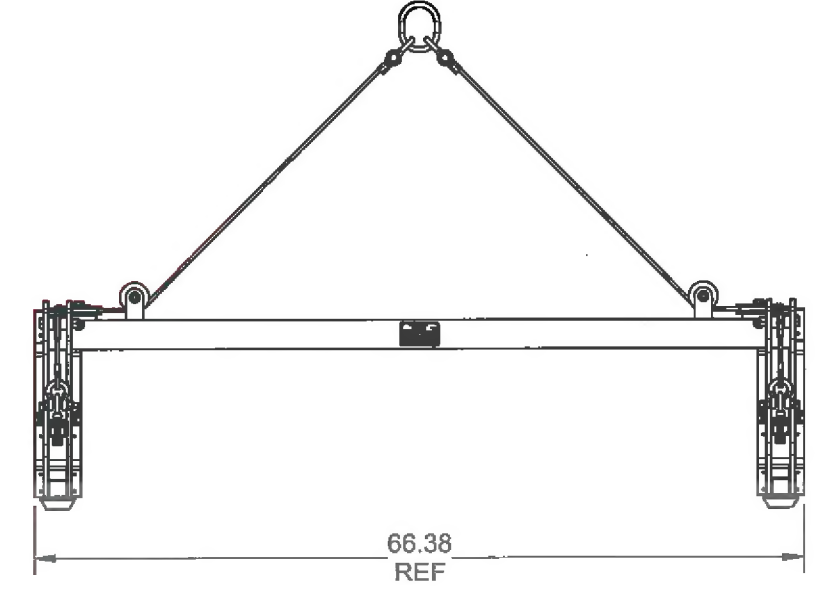
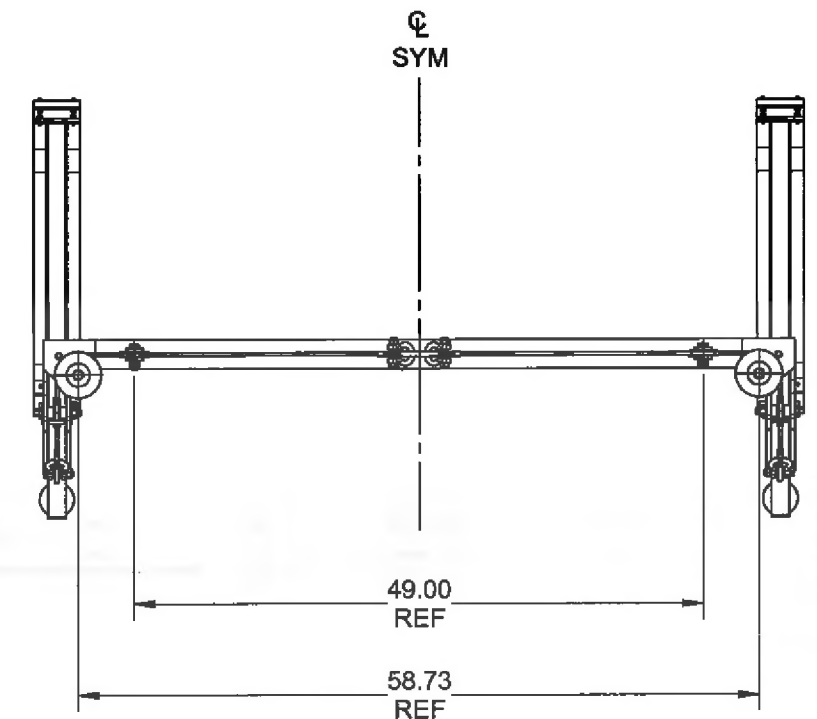
ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10321-041-M-1	CLAMP ASSEMBLY
-20	4	RB 92700-10321-041-M-20	PULLEY SPACER
25	1	RB41011	DART PLACARD
26	1	McMaster#3119T2 OR EQUIV.	STEEL OBLONG LINK 7/16" THK. X 3-1/2" INSIDE LG. X 2-9/16" INSIDE WIDTH.
27	2	McMaster#3550T34 OR EQUIV.	WIRE ROPE SLING 1/4" DIA. X 4' LG.
28	2	McMaster#3175T410 OR EQUIV.	STEEL PULLEY 4" OD. X 1/2" ID. X 13/16" THK. X 1200 LBS. CAPACITY
29	4	McMaster#3434T118 OR EQUIV.	STEEL PULLEY 2-1/2" OD. X 1/2" ID. X 1/2" THK. X 675 LBS. CAPACITY
30	4	McMaster#90081A077 OR EQUIV.	ZINC PLATED STEEL SCREW NAIL #2 SIZE X 1/4" LG.
31	6	McMaster#95615A220 OR EQUIV.	STEEL NYLON INSERT LOCKNUT 1/2"-20 X 19/32" HEIGHT
32	4	CARRLANE#CL-36521-FAS OR EQUIV.	FORGED STEEL ANCHOR SHACKLE 1/2" PIN DIA. X 3000 LBS. LOAD RATING
33	2	AN8-16A	BOLT
34	2	AN8-20A	BOLT
35	2	AN8-32A	BOLT
36	12	NAS1149F0863P	WASHER



RB 92700-10321-041-M DUAL CLAMP M/R BLADE SLING



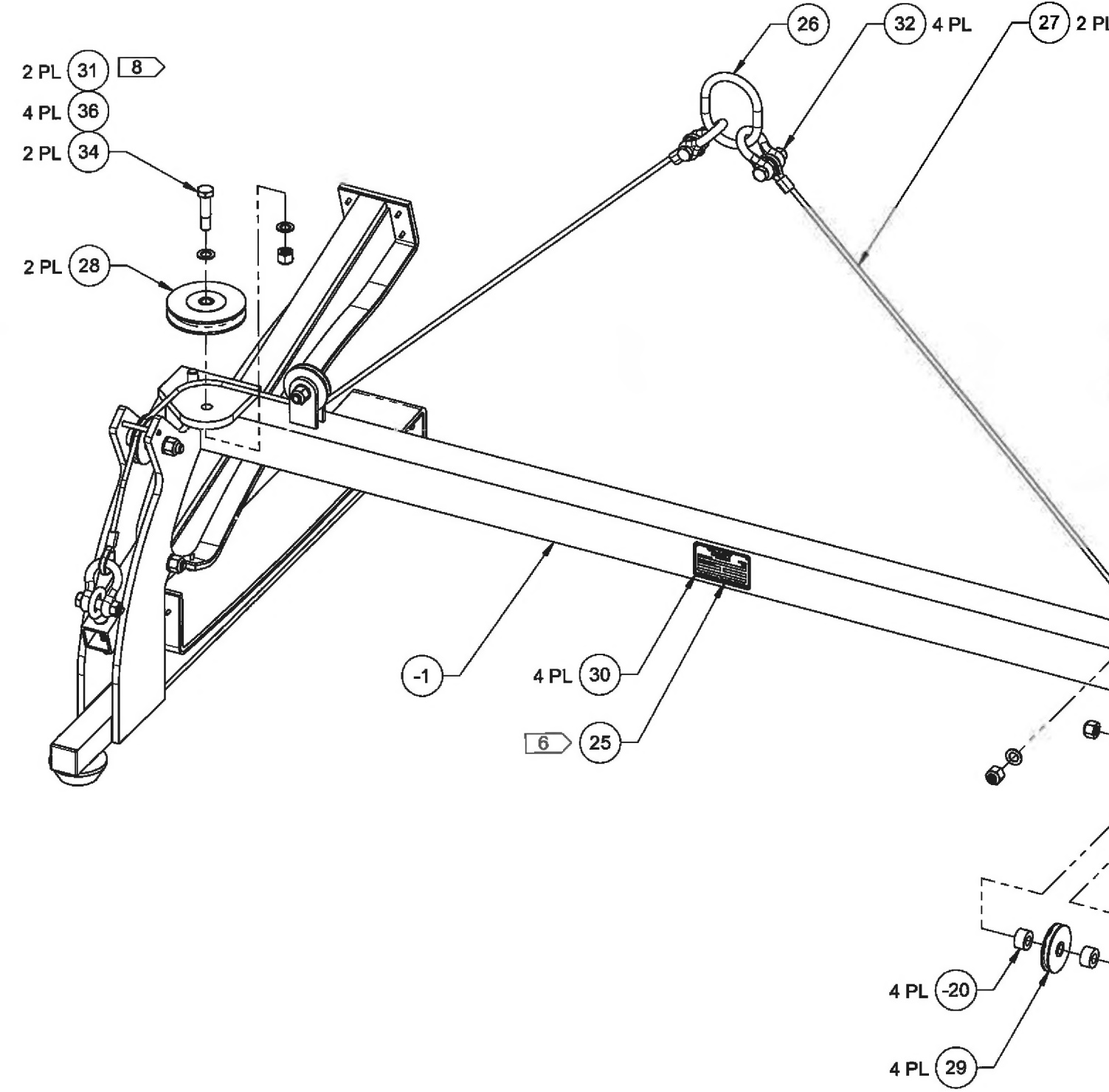
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
VP



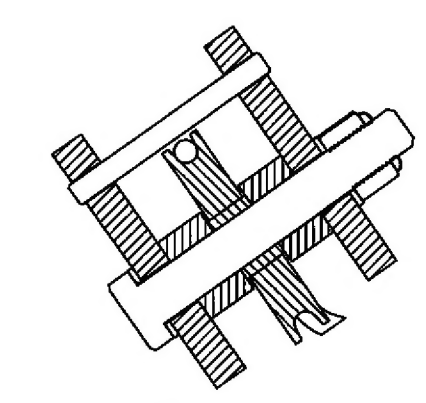
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N AND "SWL: 440 LBS" ON THE DART PLACARD WHERE INDICATED
7) ASSEMBLE AS SHOWN
8) TORQUE ITEM 31 TO 40-58 FT-LBS (480-690 IN-LBS)

A1	NEW ISSUE		KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB 92700-10321-041-M REV. A1 SHEET 1 OF 29 TITLE DUAL CLAMP M/R BLADE SLING SCALE NTS DATE 2/14/2019 COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	KPT		
CHECKED	KPT		
MFG. APPR.	DP		
APPROVED			

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SECTION A-A
2 PL

- 8 31 2 PL
- 36 4 PL
- 33 2 PL

- 2 PL 35
- 4 PL 36
- 2 PL 31 8

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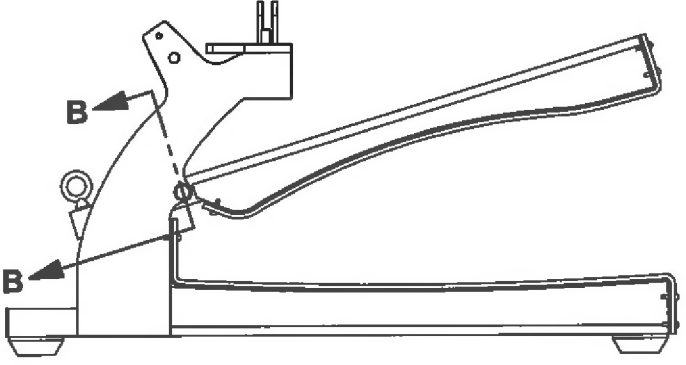
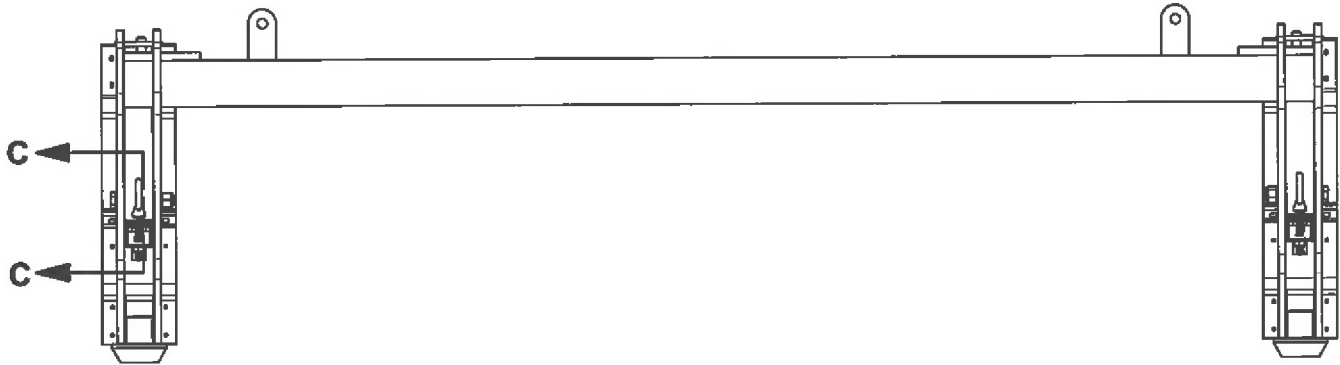
D
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DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 2 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10321-041-M-2	FRAME WELDMENT
-13	2	RB 92700-10321-041-M-13	TOP CLAMP ASSEMBLY
-19	2	RB 92700-10321-041-M-19	BOTTOM CLAMP PROTECTION
-22	2	RB 92700-10321-041-M-22	TORSION SPRING BUSHING
-23	1	RB 92700-10321-041-M-23	RIGHT HAND TORSION SPRING
-24	1	RB 92700-10321-041-M-24	LEFT HAND TORSION SPRING
37	4	McMaster#9223K68 OR EQUIV.	POLYURETHANE ROUND BUMPER 3/8"-16 X 2-15/16" DIA. X 1-7/8" OAL HEIGHT
38	2	McMaster#9565K29 OR EQUIV.	PLASTIC PLUG 1-1/2" LG. X 1-1/2" WIDTH. X 1/2" HEIGHT
39	2	McMaster#95615A220 OR EQUIV.	STEEL NYLON INSERT LOCKNUT 1/2"-20 X 19/32" HEIGHT
40	12	McMaster#97519A042 OR EQUIV.	STEEL BLIND RIVETS 5/32" DIA. X 0.675" LG.
41	2	AN8-31A	BOLT
42	4	NAS1149F0863P	WASHER

PROTOTYPE
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DATA TO ENGINEERING
WFP



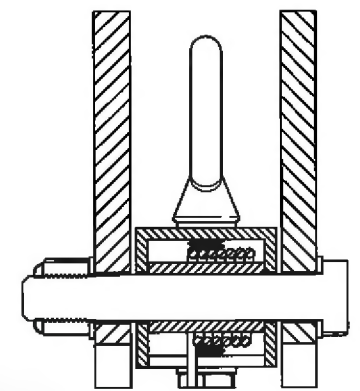
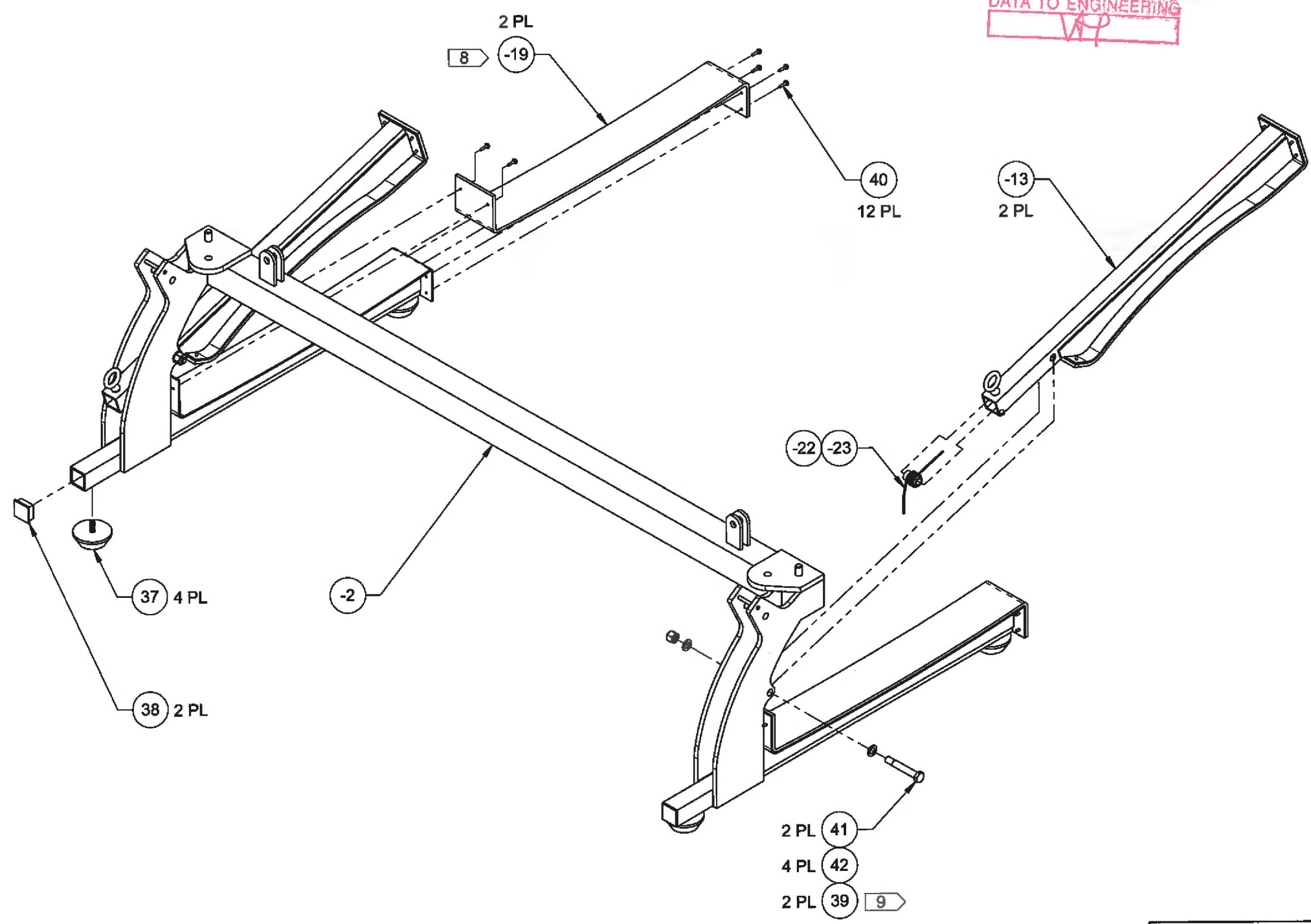
RB 92700-10321-041-M-1 CLAMP ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) APPLY 3M 1300L BETWEEN THE SURFACES OF ITEM -19 AND ITEM -2, AND REMOVE EXCESS
9) TORQUE ITEM 39 TO 40-58 FT-LBS (480-690 IN-LBS)

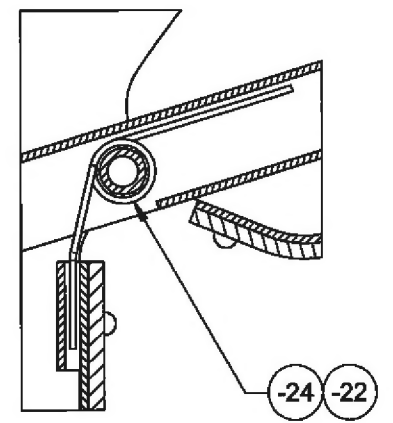
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 3 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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8 7 6 5 4 3 2 1

PROTOTYPE
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SECTION B-B
(ROTATED 17° CW)
TYP



SECTION C-C
TYP

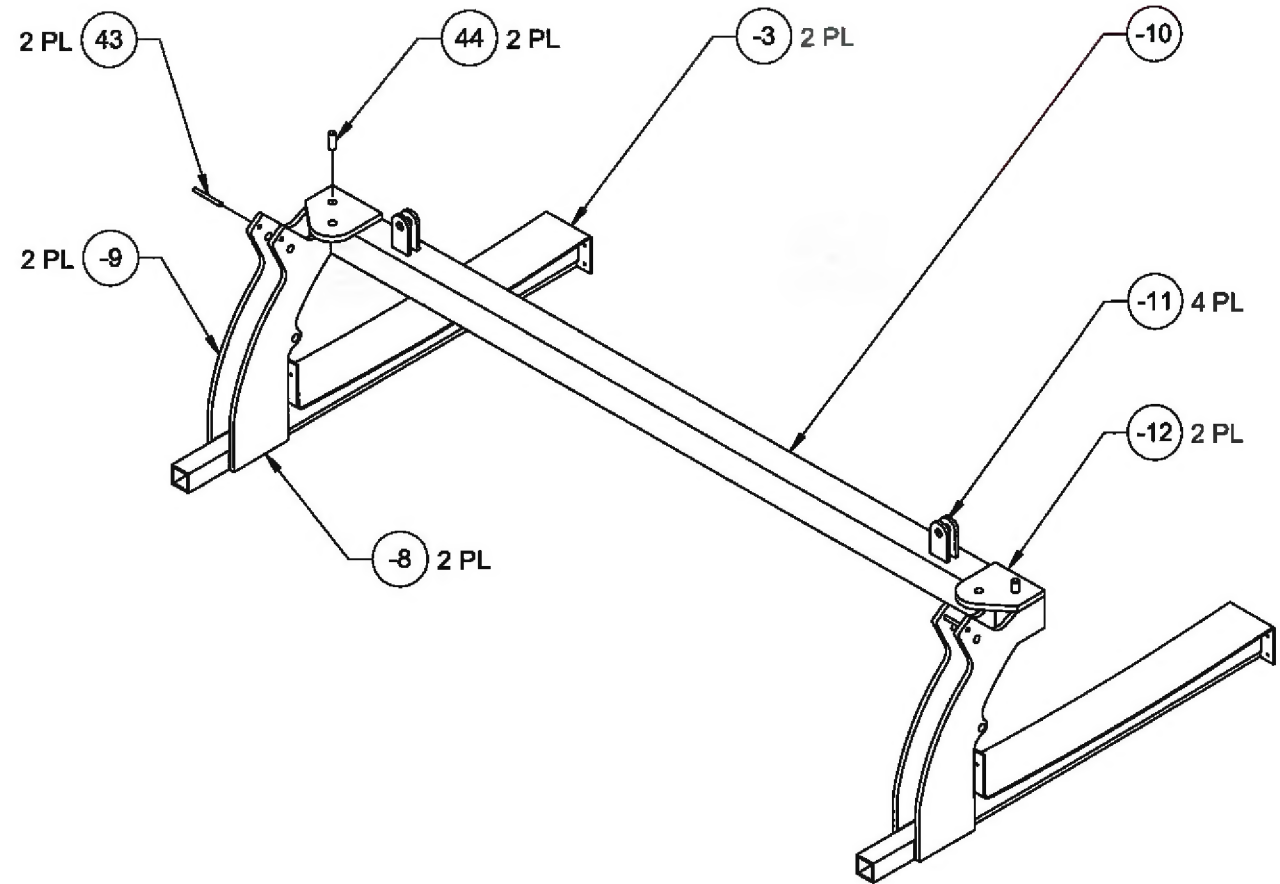
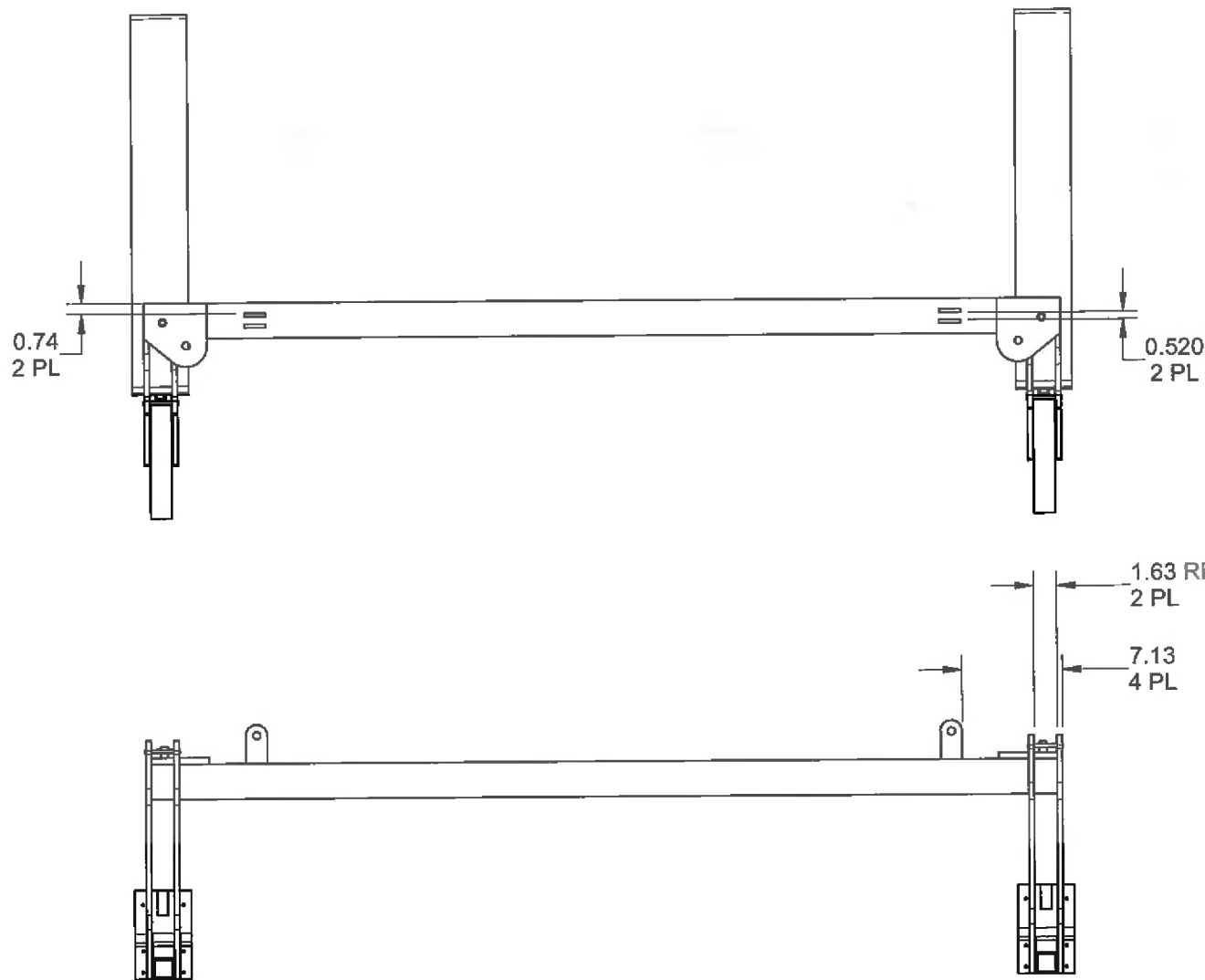
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DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 4 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
DATE 2/14/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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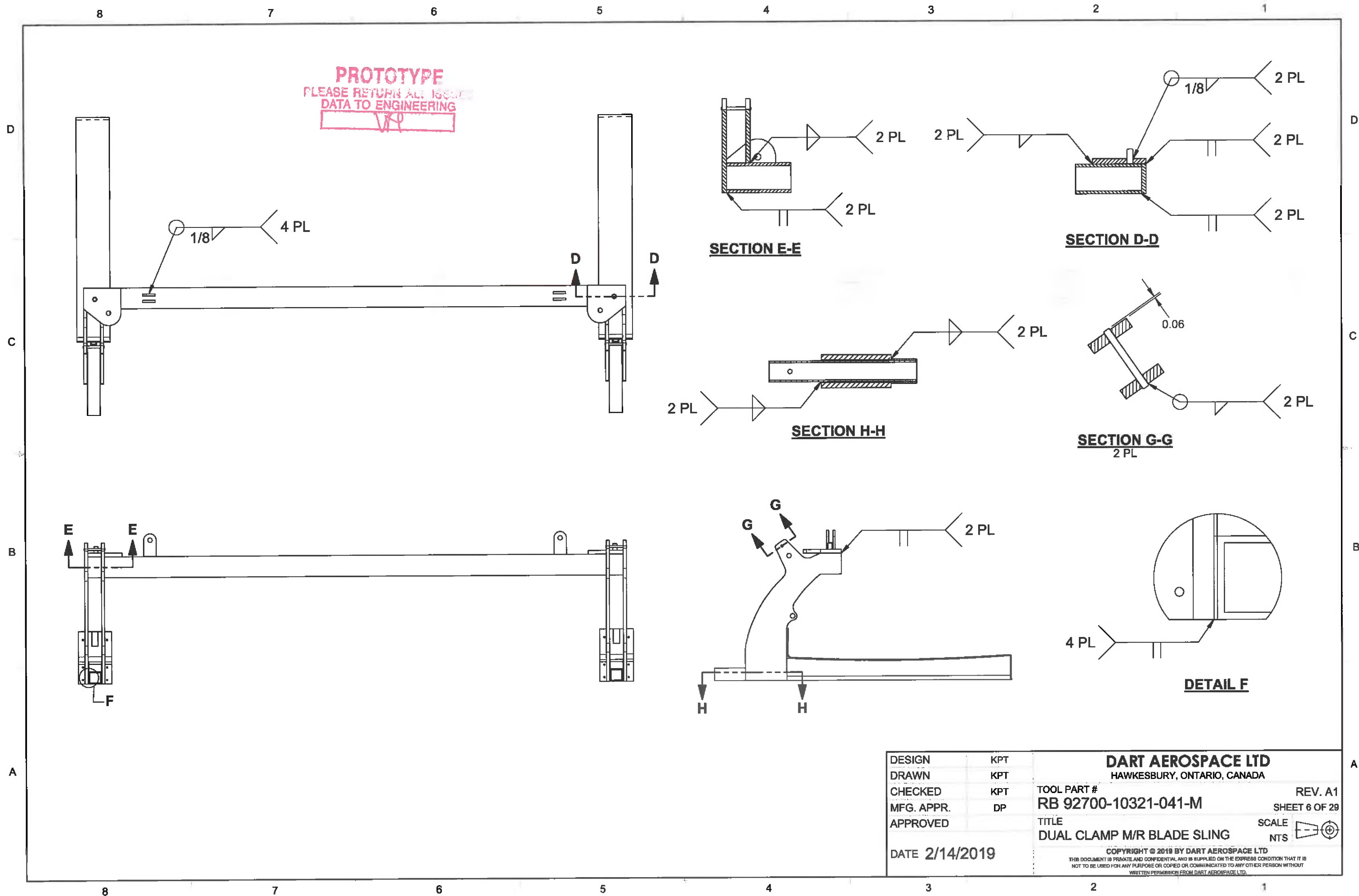
ITEM #	QTY	PART #	PART TITLE
-3	2	RB 92700-10321-041-M-3	BOTTOM CLAMP WELDMENT
-8	2	RB 92700-10321-041-M-8	INNER FRAME SUPPORT
-9	2	RB 92700-10321-041-M-9	OUTER FRAME SUPPORT
-10	1	RB 92700-10321-041-M-10	FRAME TUBE
-11	4	RB 92700-10321-041-M-11	TOP PULLEY MOUNT
-12	2	RB 92700-10321-041-M-12	SIDE PULLEY MOUNT
43	2	McMaster#98381A552 OR EQUIV.	STEEL DOWEL PIN 1/4" DIA. X 2-1/2" LG.
44	2	McMaster#98381A714 OR EQUIV.	STEEL DOWEL PIN 1/2" DIA. X 1-1/4" LG.



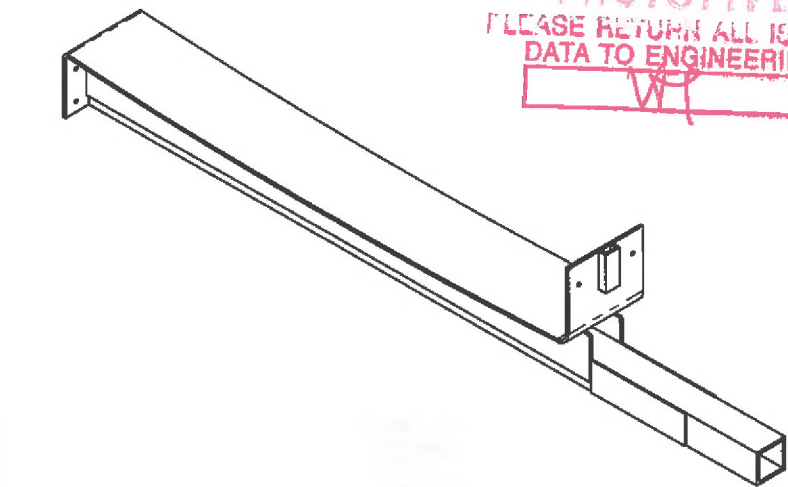
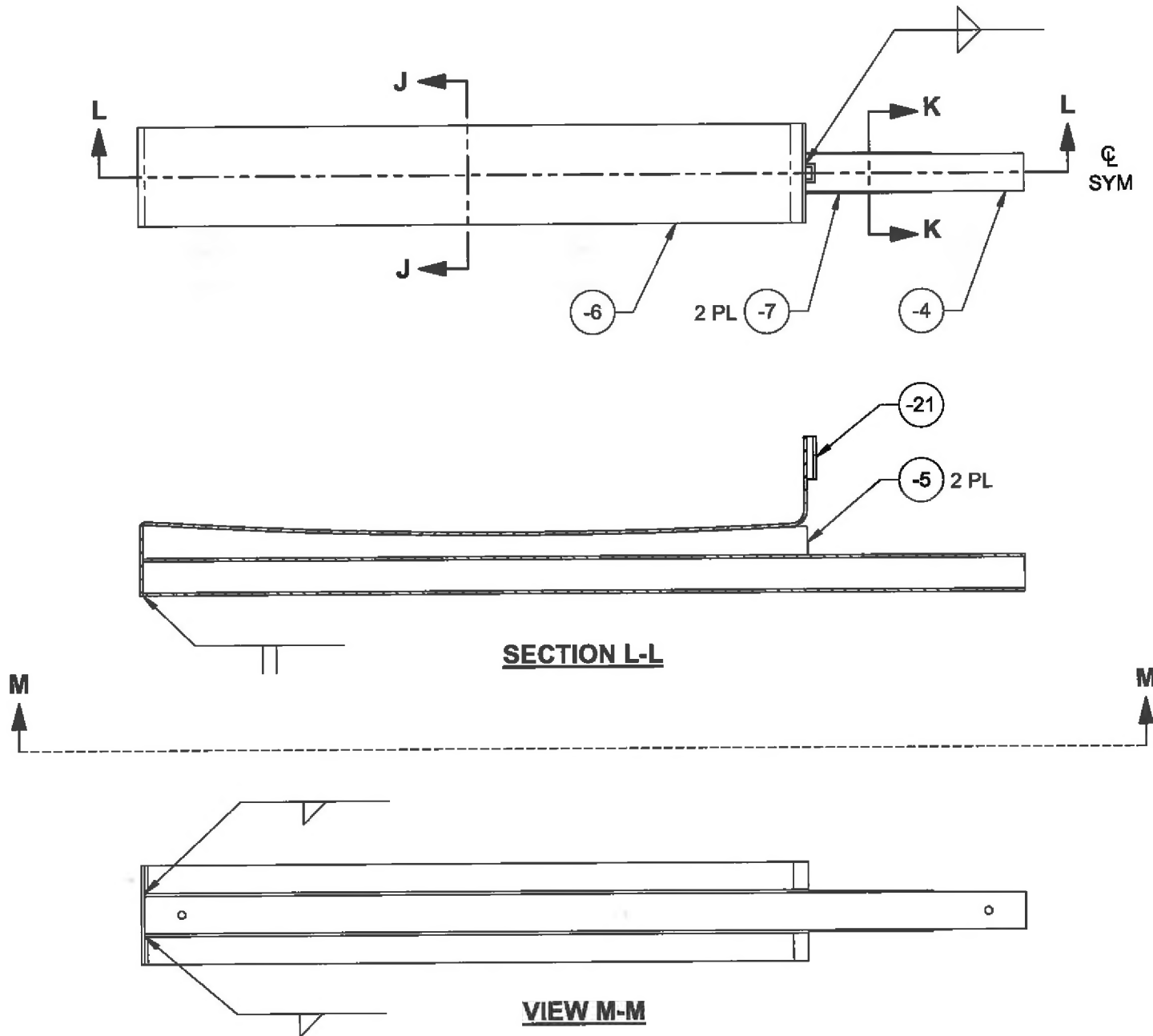
RB 92700-10321-041-M-2 FRAME WELDMENT

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: POWDERCOAT RED QSI 005 OR MIL-PRF-24712
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL WELD SPLATTERS
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) MASK ALL HOLES PRIOR TO POWDERCOAT

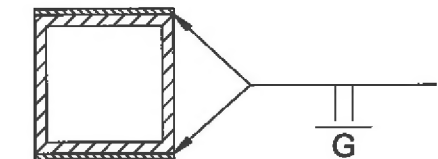
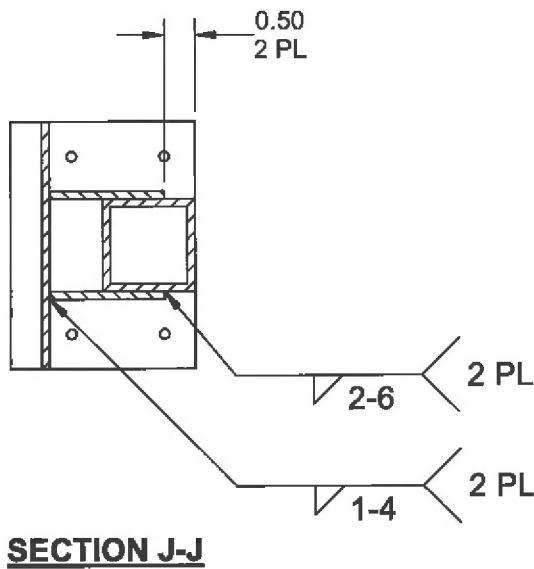
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 5 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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ITEM #	QTY	PART #	PART TITLE
-4	1	RB 92700-10321-041-M-4	BOTTOM CLAMP TUBE
-5	2	RB 92700-10321-041-M-5	BOTTOM CLAMP SUPPORT
-6	1	RB 92700-10321-041-M-6	BOTTOM CLAMP PROFILE
-7	2	RB 92700-10321-041-M-7	SPACER
-21	1	RB 92700-10321-041-M-21	TORSION SPRING HOLDER



RB 92700-10321-041-M-3 BOTTOM CLAMP WELDMENT



SECTION K-K

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL WELD SPLATTERS
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 7 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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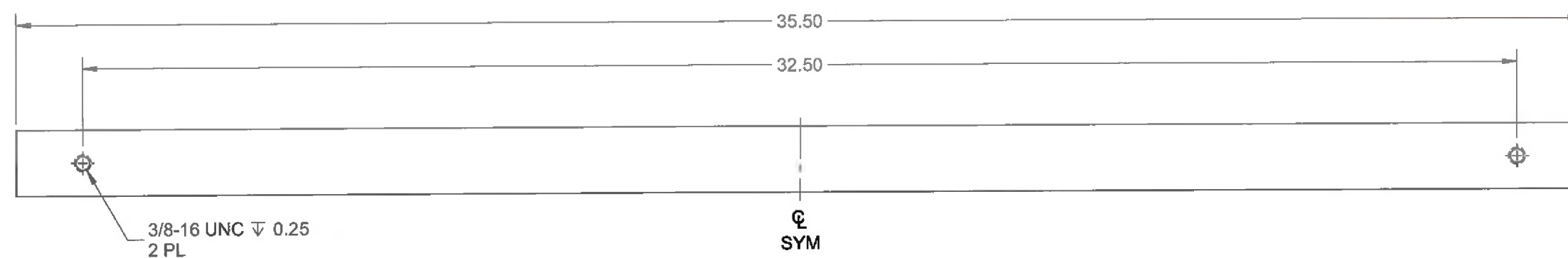
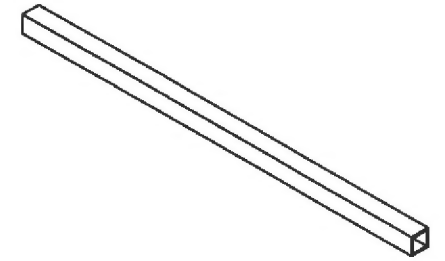
B

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PROTOTYPE
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RB 92700-10321-041-M-4 BOTTOM CLAMP TUBE

NOTES:

1) MATERIAL: A513 TYPE 5 DOM TUBING

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

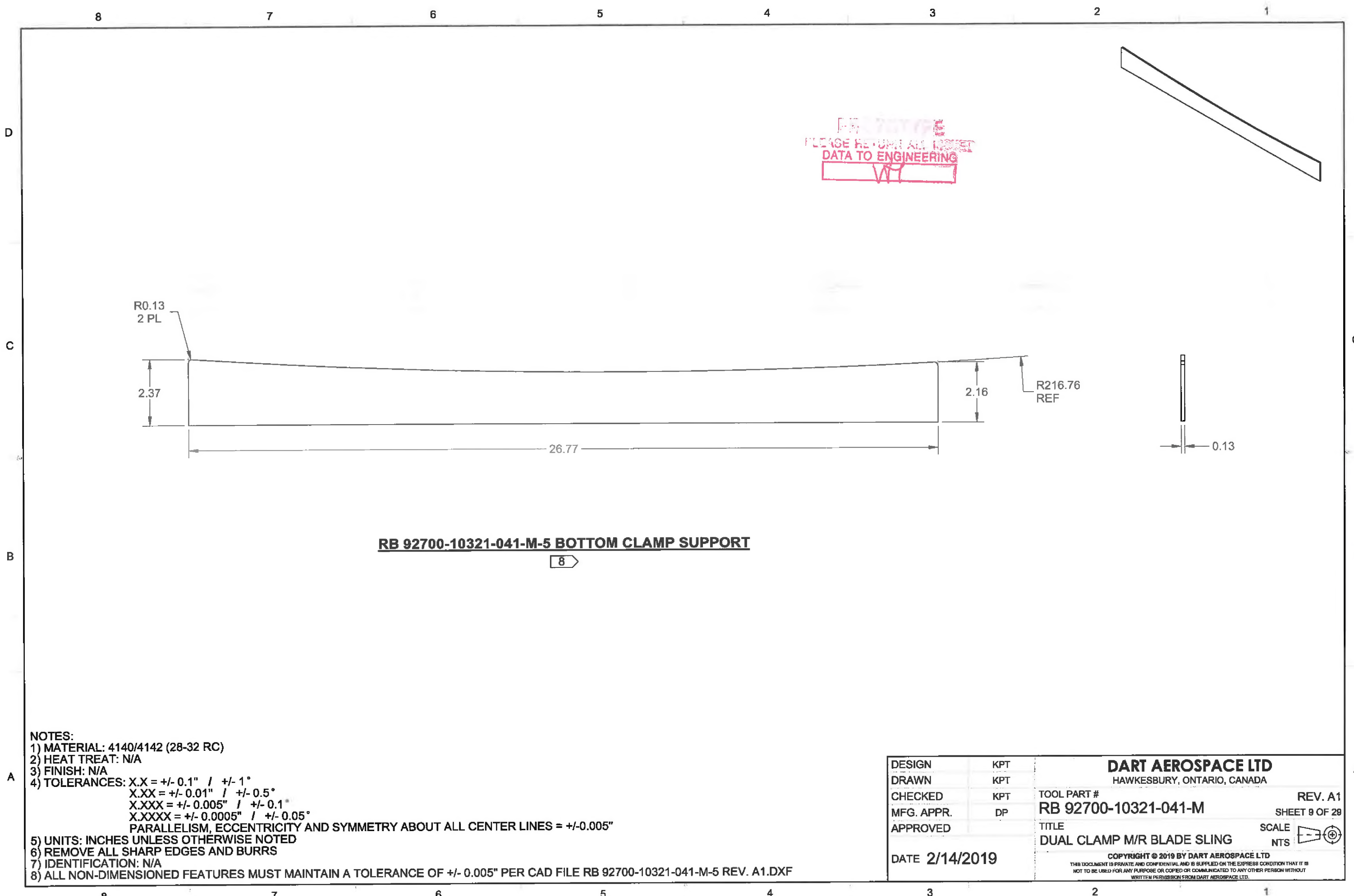
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

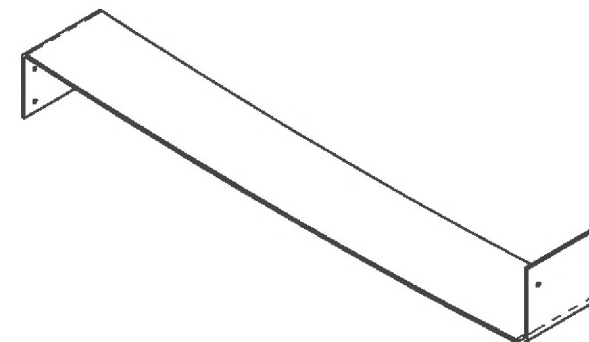
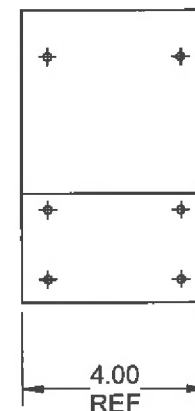
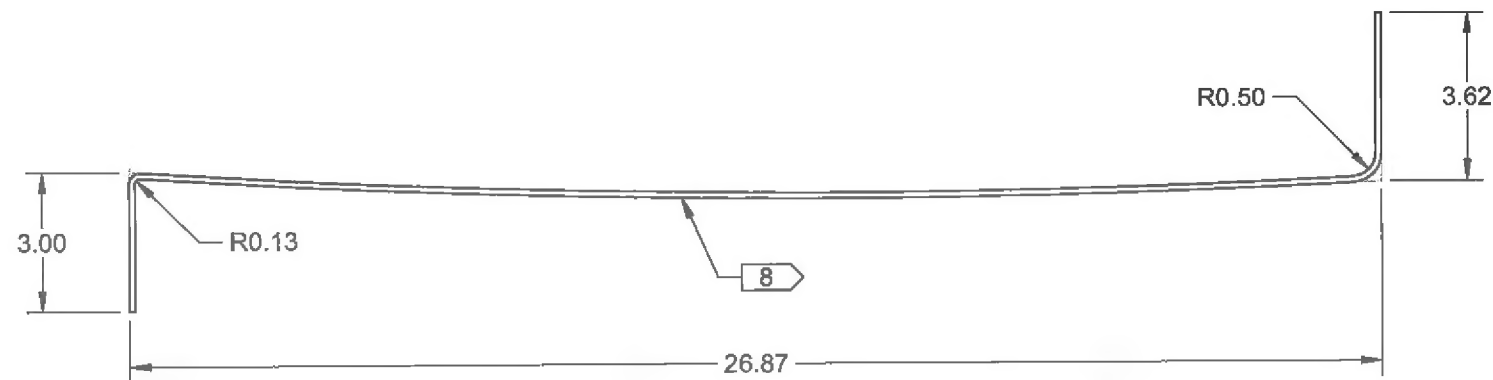
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 8 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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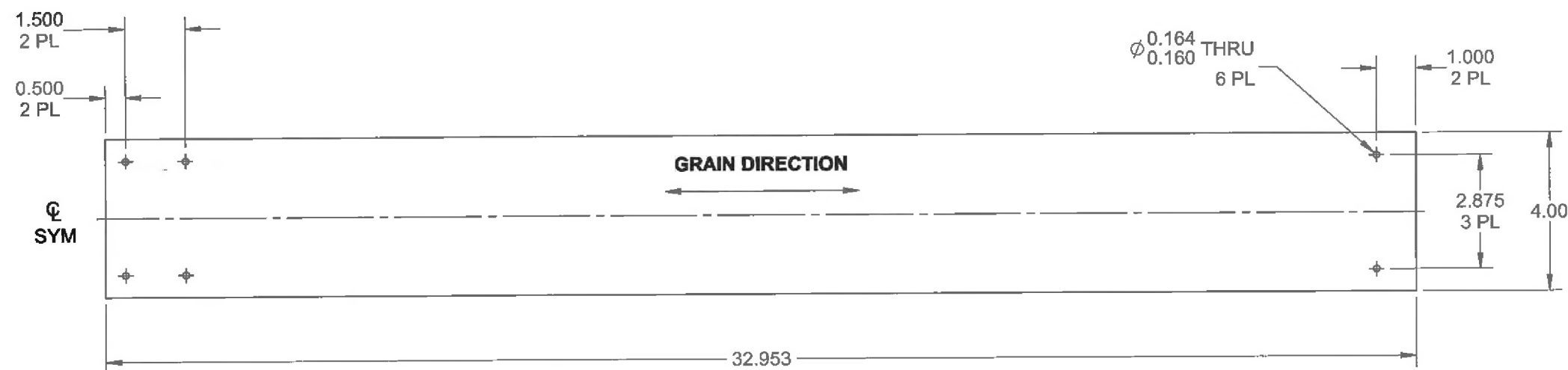
NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10321-041-M-5 REV. A1.DXF

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 9 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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RB 92700-10321-041-M-6 BOTTOM CLAMP PROFILE

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FLAT PATTERN

NOTES:

1) MATERIAL: A36/1018/1020/1025 HR

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°


PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

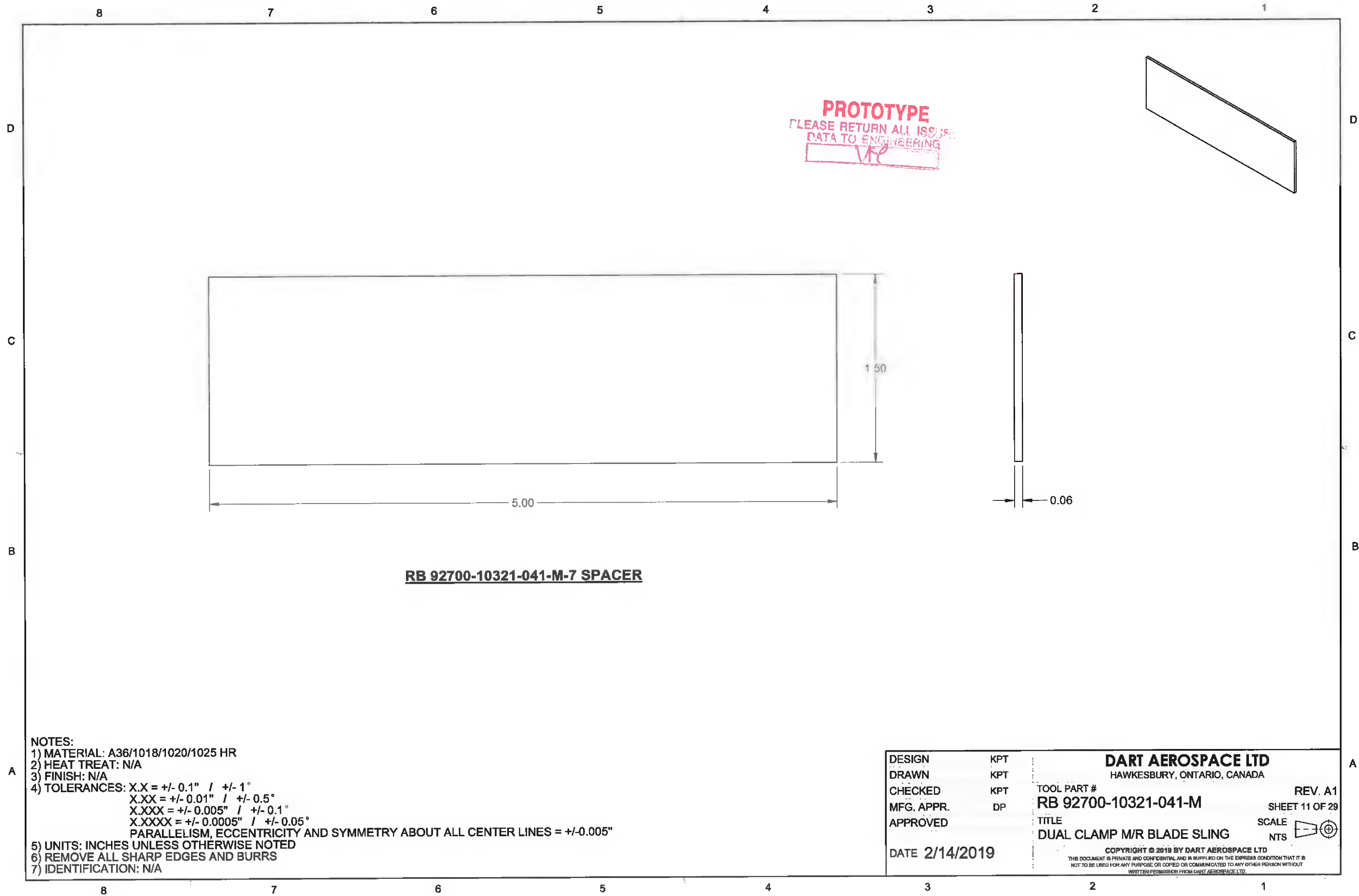
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

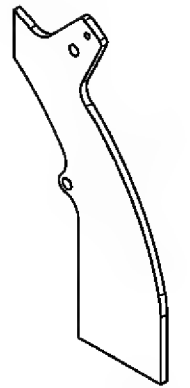
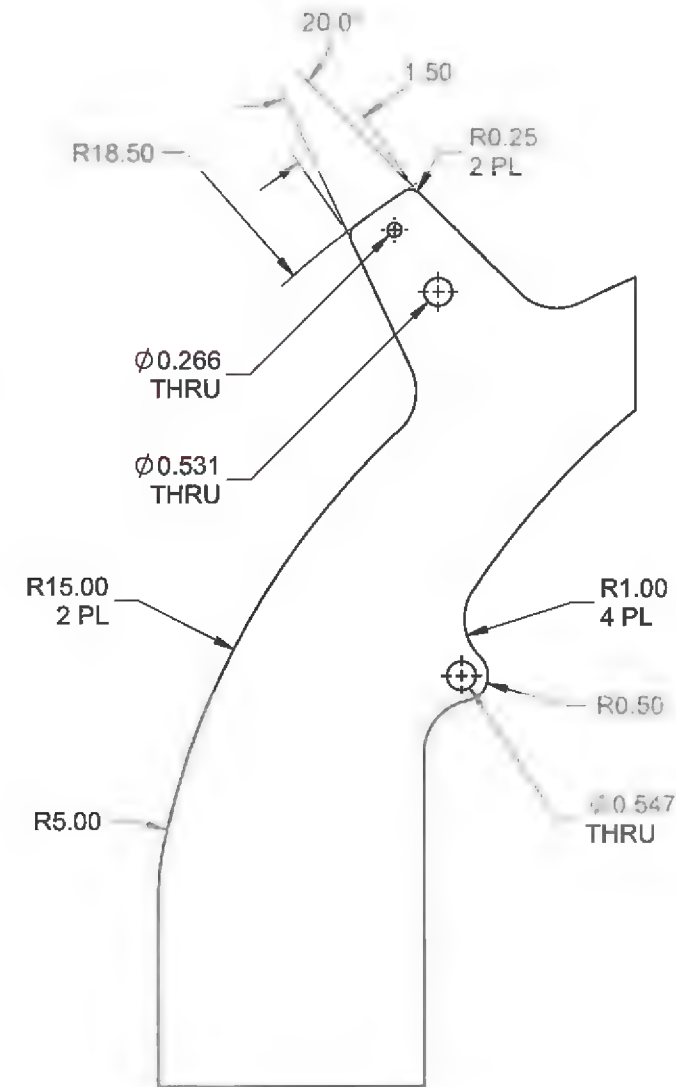
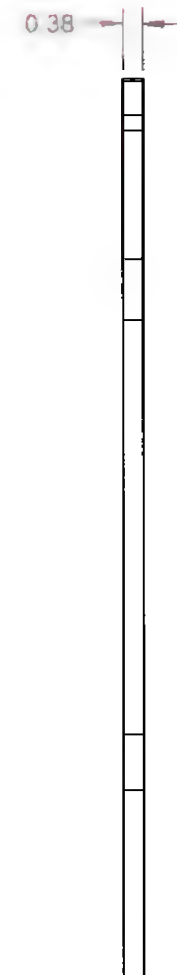
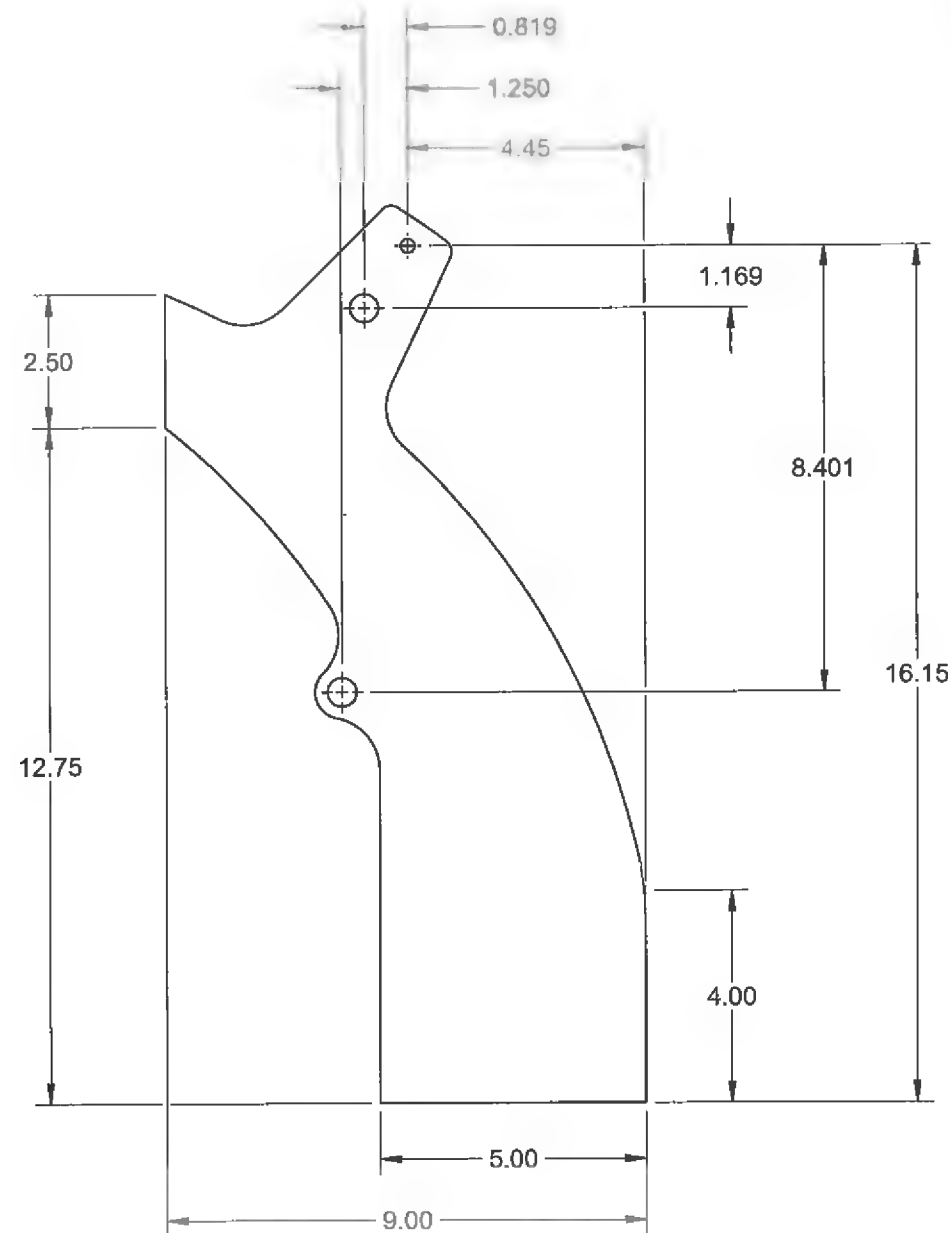
7) IDENTIFICATION: N/A

8) BEND ACCORDING TO PROFILE OF ITEM -5 AT ASSEMBLY

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 10 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS 
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RB 92700-10321-041-M-8 INNER FRAME SUPPORT

8

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10321-041-M-8 REV. A1.DXF

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DATE 2/14/2019

KPT
KPT
KPT
DP

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RB 92700-10321-041-M

TITLE
DUAL CLAMP M/R BLADE SLING

REV. A1
SHEET 12 OF 29

SCALE
NTS

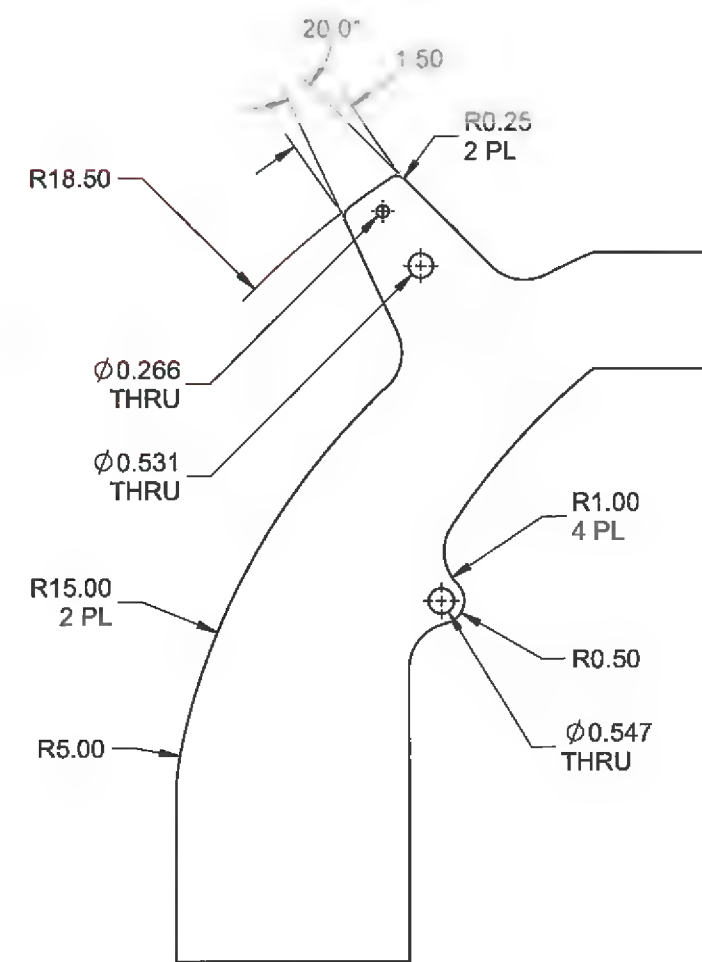
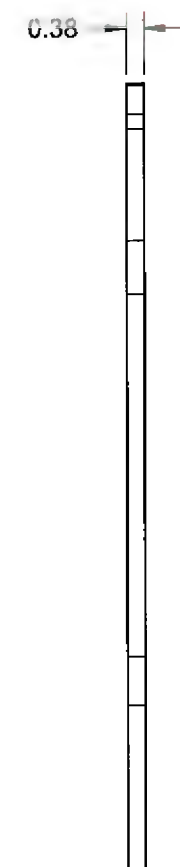
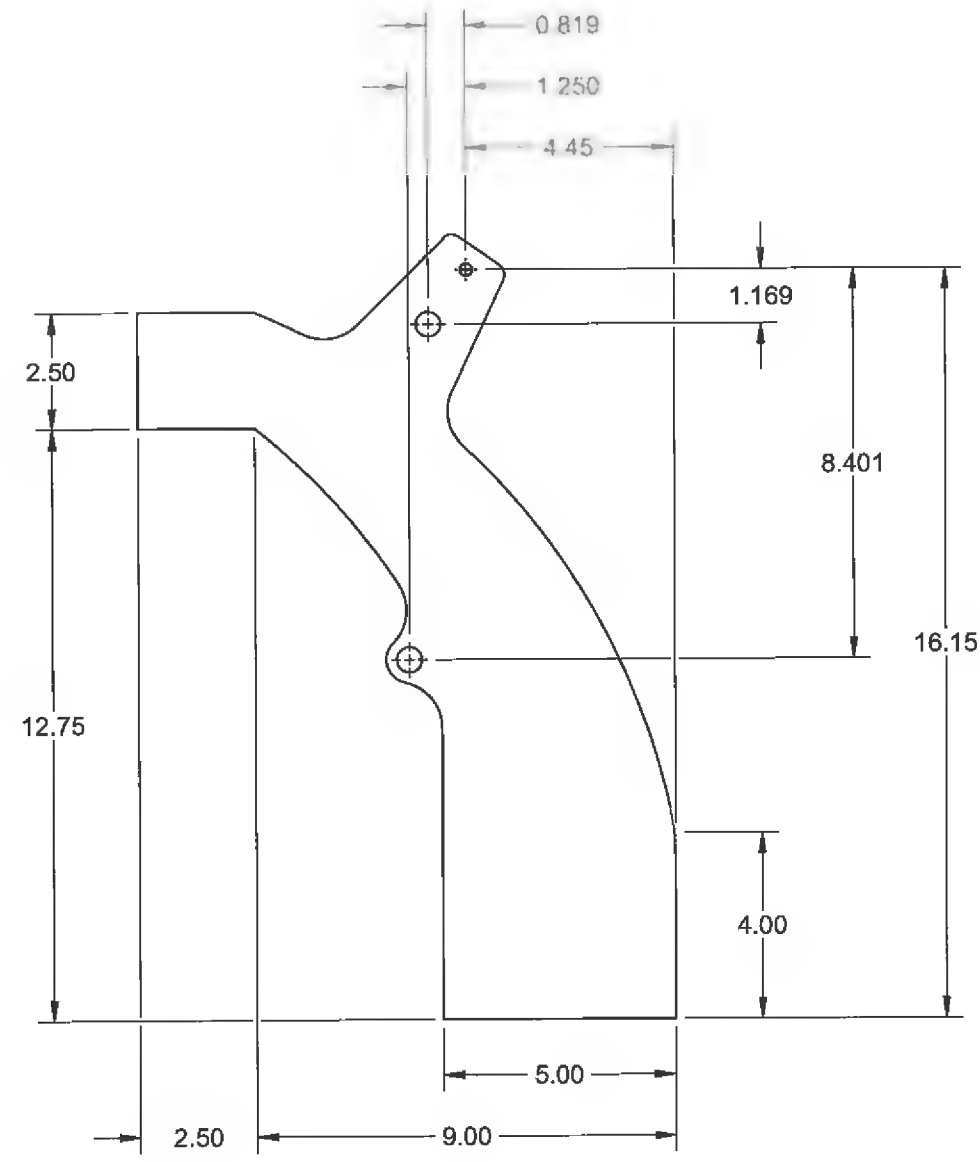
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RB 92700-10321-041-M-9 OUTER FRAME SUPPORT

8

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10321-041-M-9 REV. A1.DXF

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	TOOL PART # RB 92700-10321-041-M	REV. A1 SHEET 13 OF 29
DRAWN	KPT			
CHECKED	KPT			
MFG. APPR.	DP			
APPROVED				
DATE 2/14/2019		TITLE DUAL CLAMP M/R BLADE SLING		
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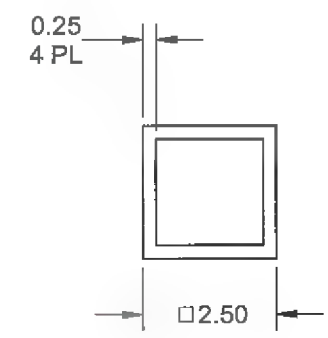
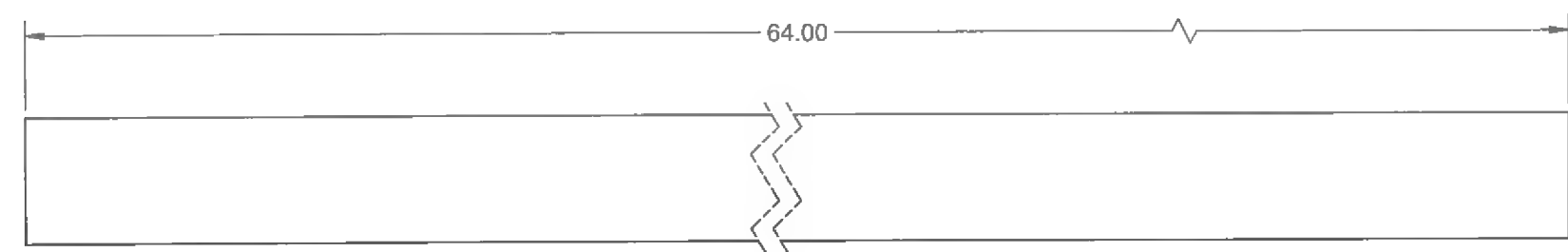
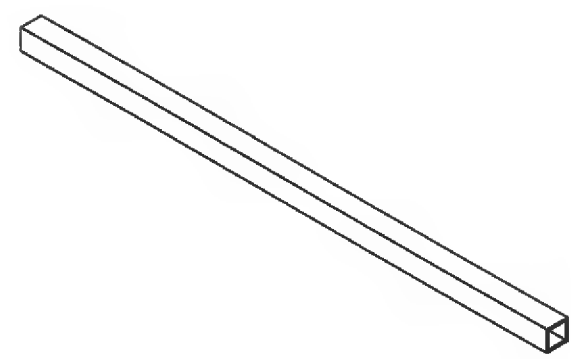
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
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RB 92700-10321-041-M-10 FRAME TUBE

NOTES:
1) MATERIAL: A513 TYPE 5 DOM TUBING
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 14 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
DATE 2/14/2019		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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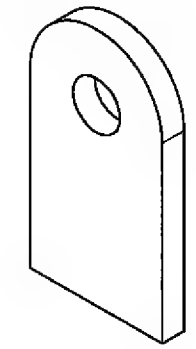
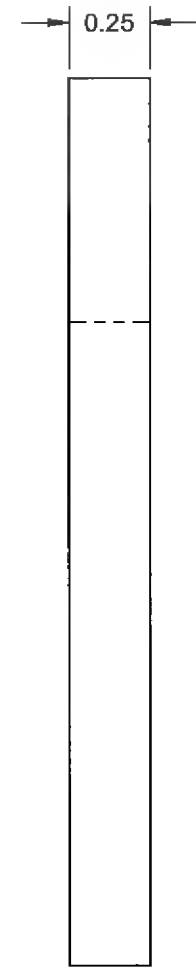
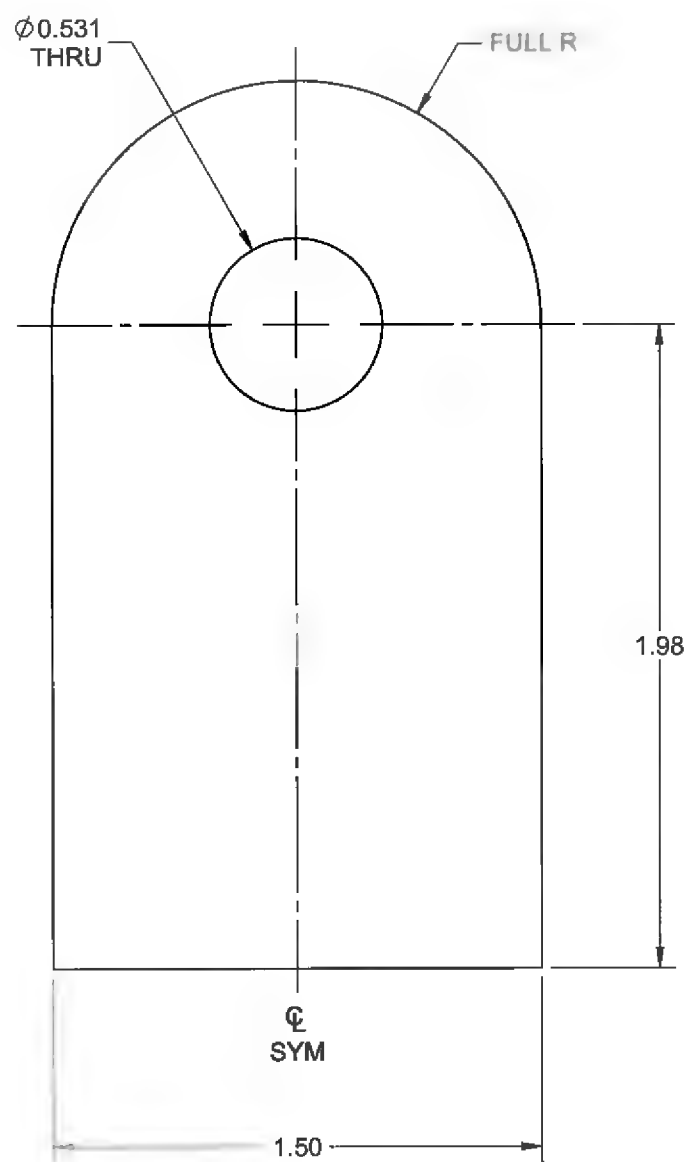
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PLACES WHERE REQUIRED
DATA TO ENGINEERING
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RB 92700-10321-041-M-11 TOP PULLEY MOUNT

NOTES:

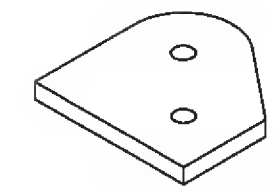
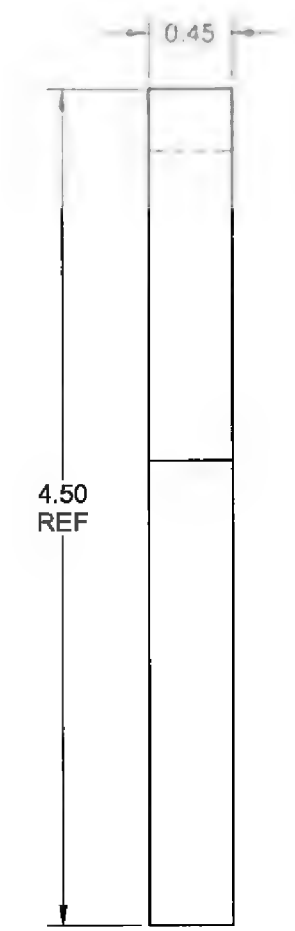
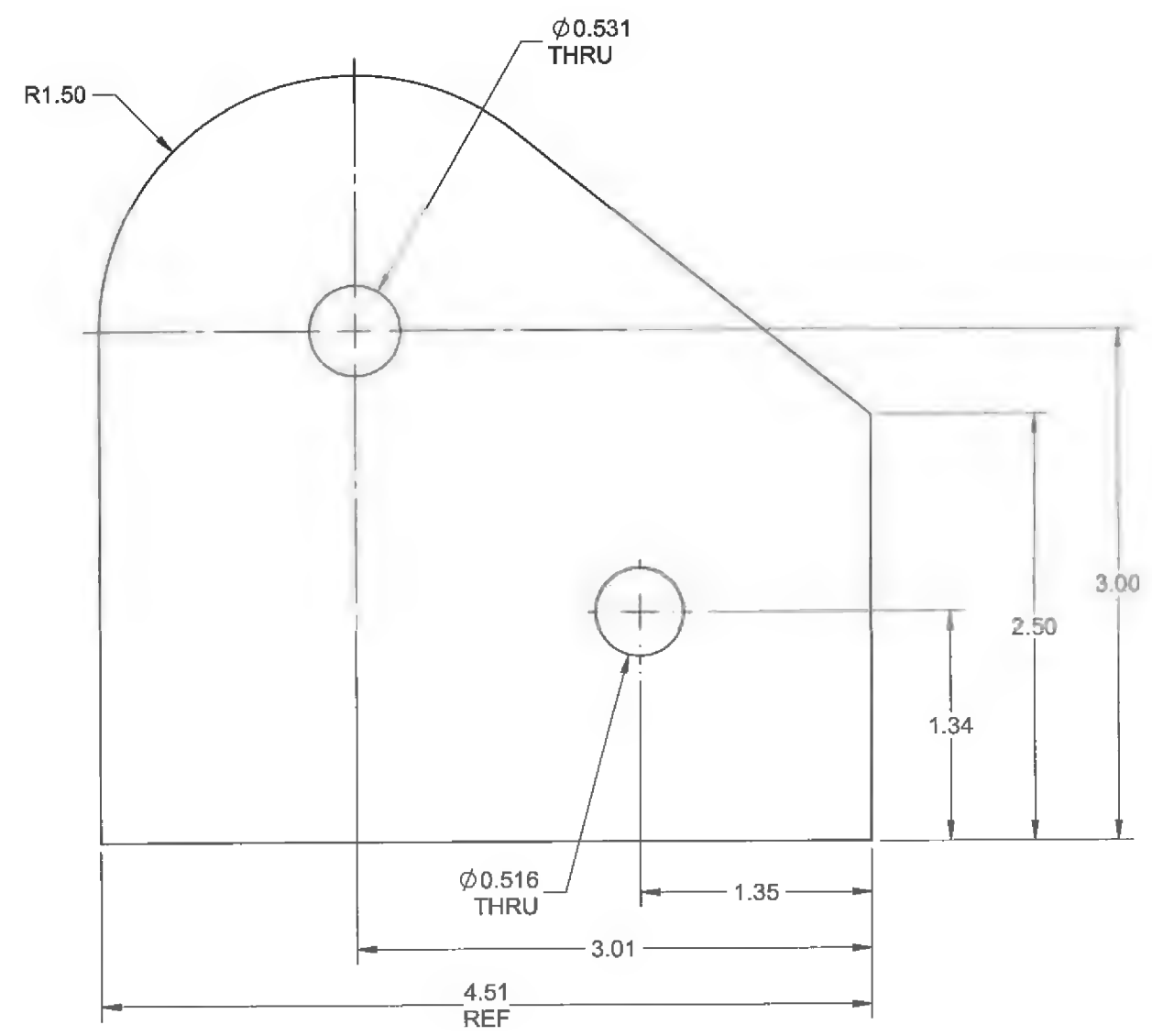
- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	TOOL PART # RB 92700-10321-041-M	REV. A1 SHEET 15 OF 29
DRAWN	KPT			
CHECKED	KPT			
MFG. APPR.	DP			
APPROVED		TITLE DUAL CLAMP M/R BLADE SLING		
DATE 2/14/2019		SCALE NTS		
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RB 92700-10321-041-M-12 SIDE PULLEY MOUNT

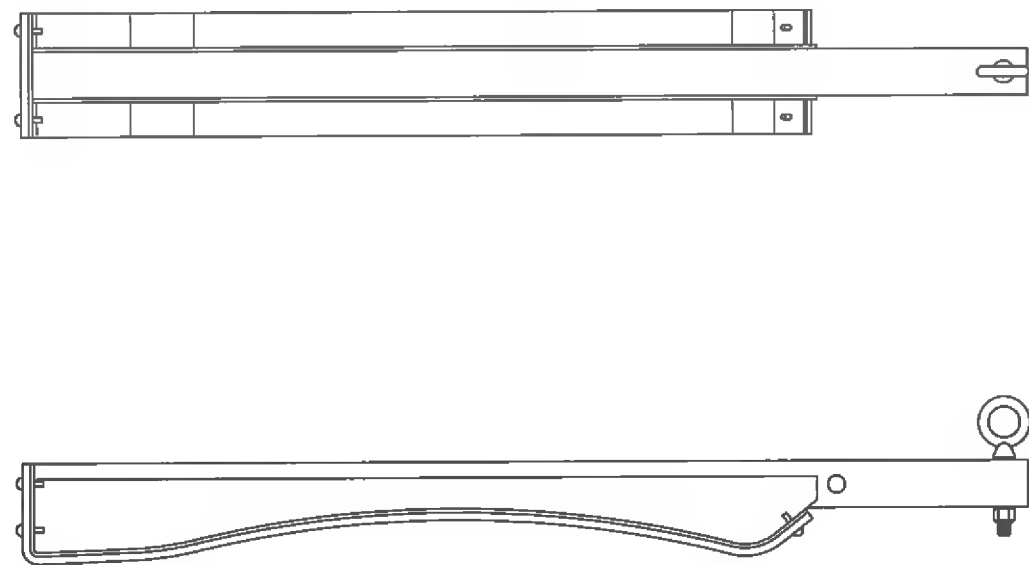
PROTOTYPE
FACE 62700-11-1000-00
DATA TO ENGINEERING
VP

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

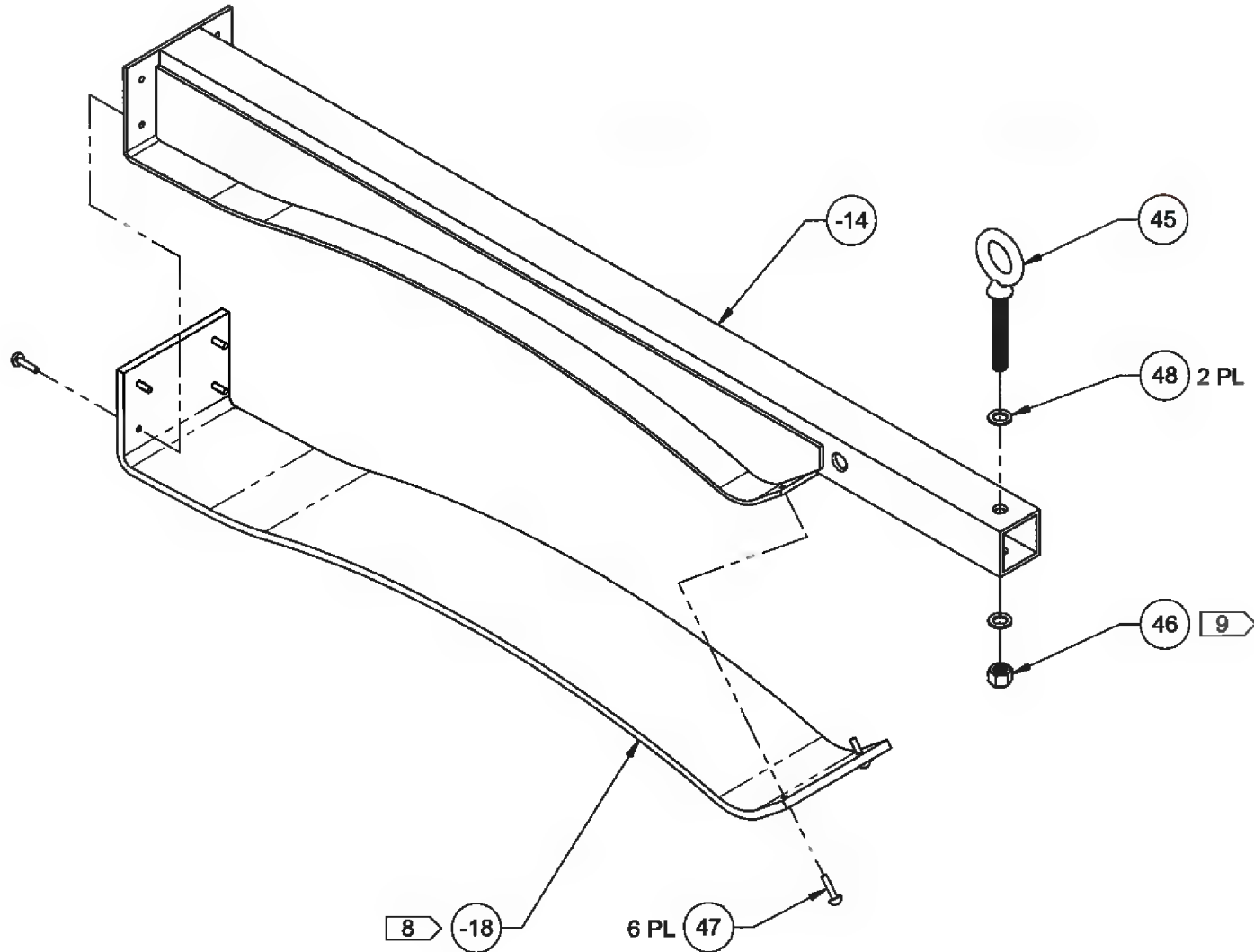
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	TOOL PART # RB 92700-10321-041-M	REV. A1 SHEET 16 OF 29
DRAWN	KPT			
CHECKED	KPT			
MFG. APPR.	DP			
APPROVED				
DATE 2/14/2019		TITLE DUAL CLAMP M/R BLADE SLING		
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ITEM #	QTY	PART #	PART TITLE
-14	1	RB 92700-10321-041-M-14	TOP CLAMP WELDMENT
-18	1	RB 92700-10321-041-M-18	TOP CLAMP PROTECTION
45	1	McMaster#3014T142 OR EQUIV.	STEEL EYEBOLT 3/8"-16 X 2-1/2" THREAD LG. X 1" EYE DIA. X 4-1/2" LG.
46	1	McMaster#95615A140 OR EQUIV.	STEEL NYLON INSERT LOCKNUT 3/8"-16 X 29/64" HEIGHT.
47	6	McMaster#97519A042 OR EQUIV.	STEEL BLIND RIVETS 5/32" DIA. X 0.675" LG.
48	2	NAS1149F0663P	WASHER



RB 92700-10321-041-M-13 TOP CLAMP ASSEMBLY



NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) APPLY 3M 1300L BETWEEN THE SURFACES OF ITEM -18 AND ITEM -14, AND REMOVE EXCESS
9) TORQUE ITEM 46 TO 13-15 FT-LBS (160-185 IN-LBS)

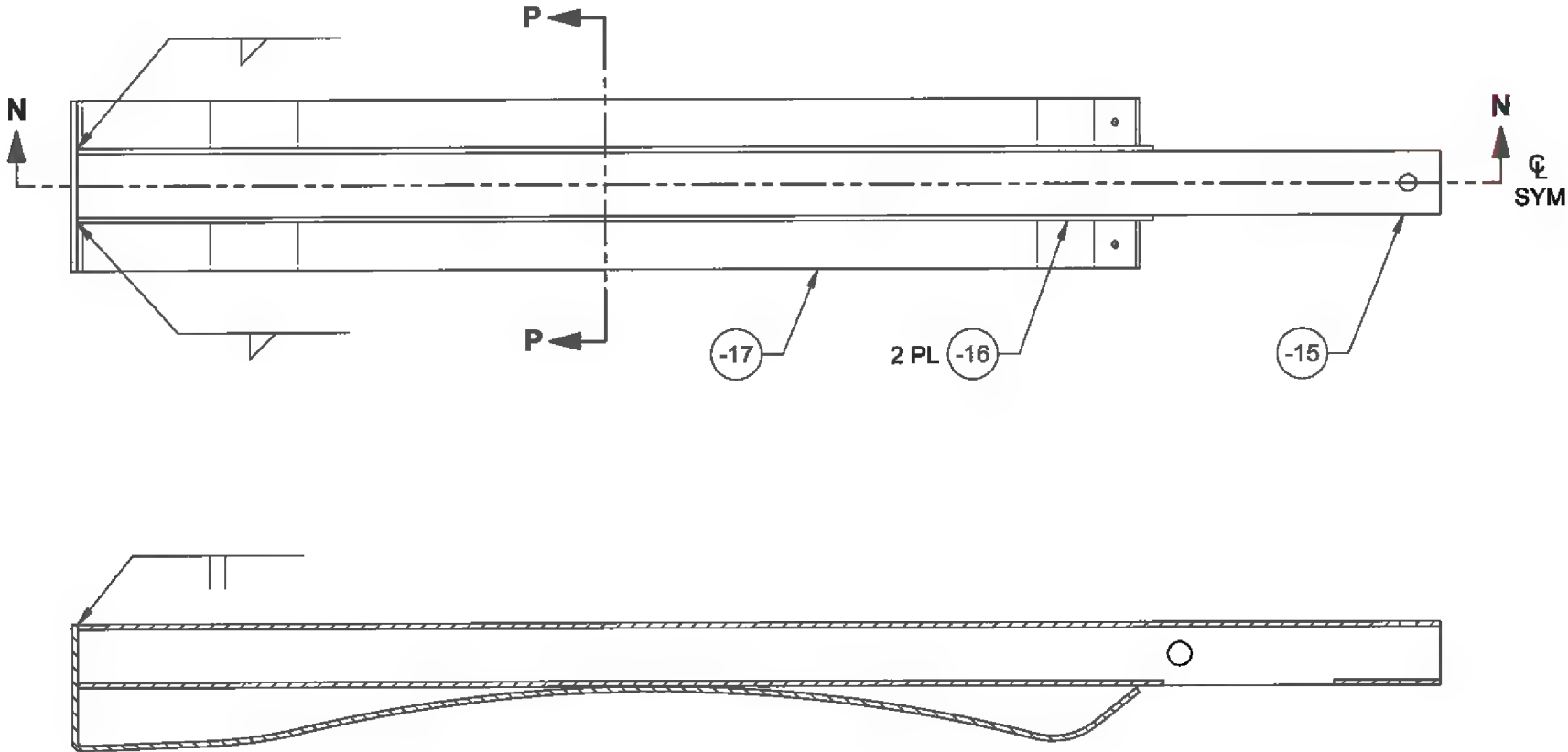
DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DATE 2/14/2019

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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
TOOL PART #
RB 92700-10321-041-M
TITLE
DUAL CLAMP M/R BLADE SLING
REV. A1
SHEET 17 OF 29
SCALE
NTS
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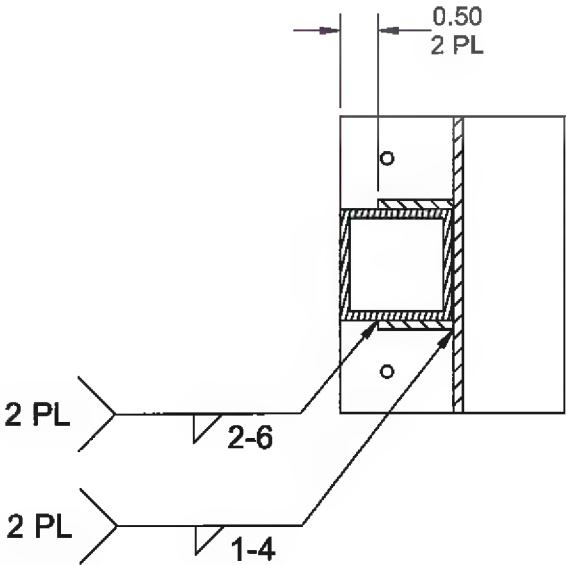
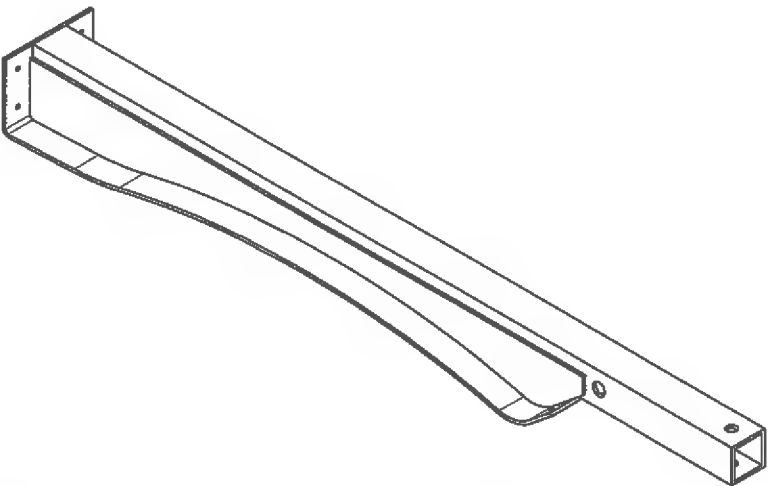
ITEM #	QTY	PART #	PART TITLE
-15	1	RB 92700-10321-041-M-15	TOP CLAMP TUBE
-16	2	RB 92700-10321-041-M-16	TOP CLAMP SUPPORT
-17	1	RB 92700-10321-041-M-17	TOP CLAMP PROFILE

PROTOTYPE
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SECTION N-N

RB 92700-10321-041-M-14 TOP CLAMP WELDMENT



SECTION P-P

- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: POWDERCOAT RED QSI 005 OR MIL-PRF-24712
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) REMOVE ALL WELD SPLATTERS
 7) IDENTIFICATION: N/A
 8) ASSEMBLE AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB 92700-10321-041-M TITLE DUAL CLAMP M/R BLADE SLING COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. A1
DRAWN	KPT		SHEET 18 OF 29
CHECKED	KPT		SCALE
MFG. APPR.	DP		NTS
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DATE 2/14/2019

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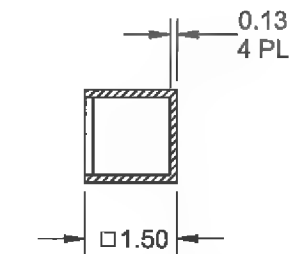
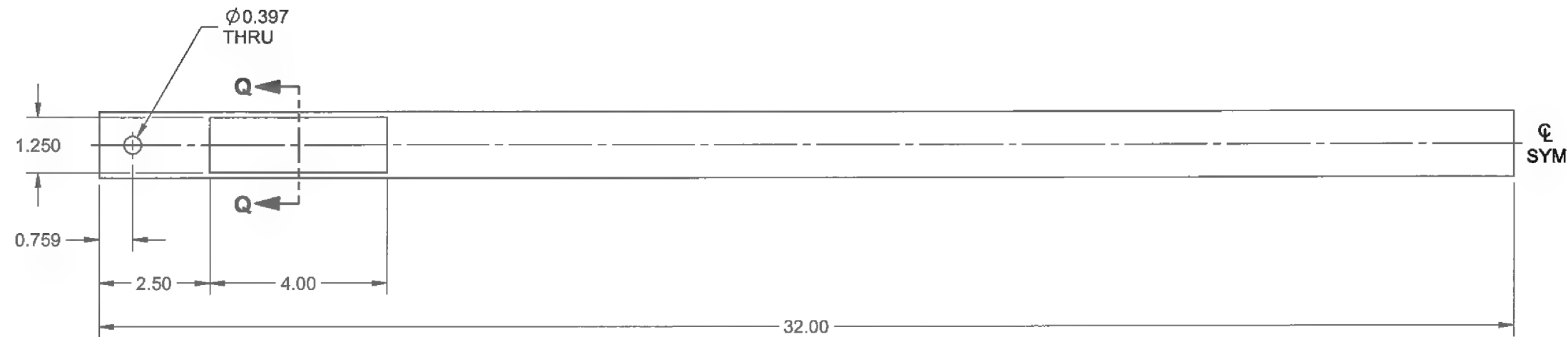
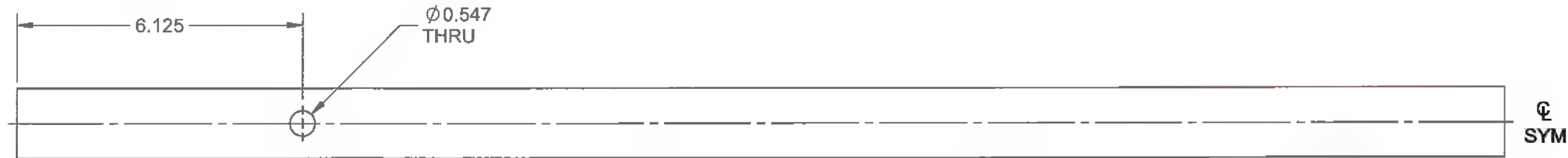
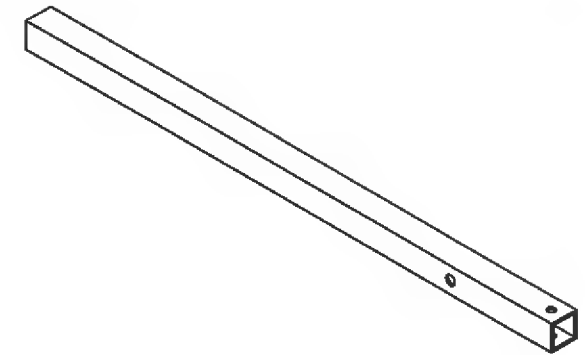
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
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SECTION Q-Q

RB 92700-10321-041-M-15 TOP CLAMP TUBE

NOTES:

1) MATERIAL: A513 TYPE 5 DOM TUBING

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN

KPT

DRAWN

KPT

CHECKED

KPT

MFG. APPR.

DP

APPROVED

DATE 2/14/2019

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

TOOL PART #

RB 92700-10321-041-M

TITLE

DUAL CLAMP M/R BLADE SLING

REV. A1

SHEET 19 OF 29

SCALE

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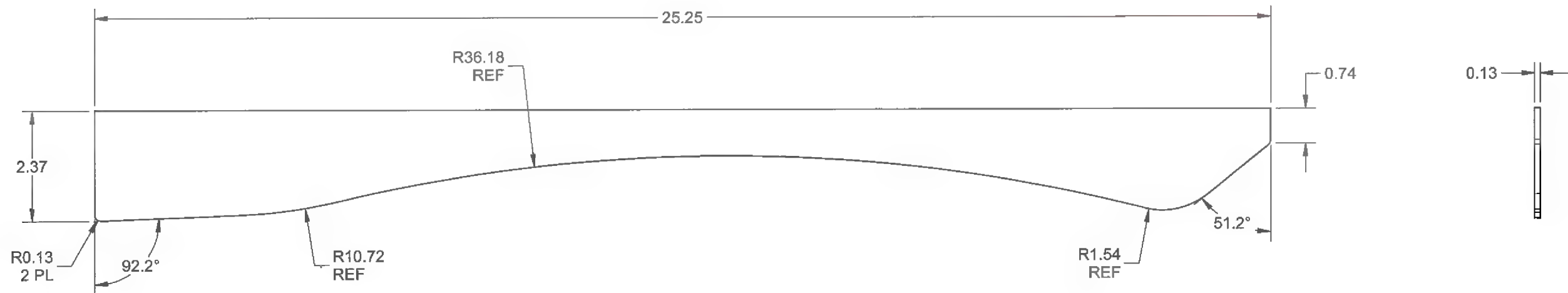
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PROTOTYPE
PLEASE RETURN ALL ISSUES
DATA TO ENGINEERING
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RB 92700-10321-041-M-16 TOP CLAMP SUPPORT

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NOTES:

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10321-041-M-16 REV. A1.DXF

DESIGN

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CHECKED

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MFG. APPR.

DP

APPROVED

DATE 2/14/2019

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

TOOL PART #

RB 92700-10321-041-M

TITLE

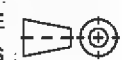
DUAL CLAMP M/R BLADE SLING

REV. A1

SHEET 20 OF 29

SCALE

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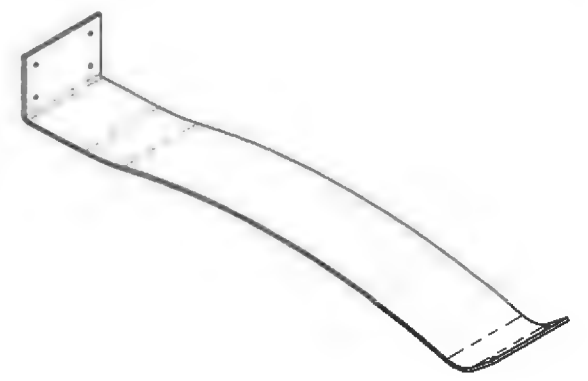
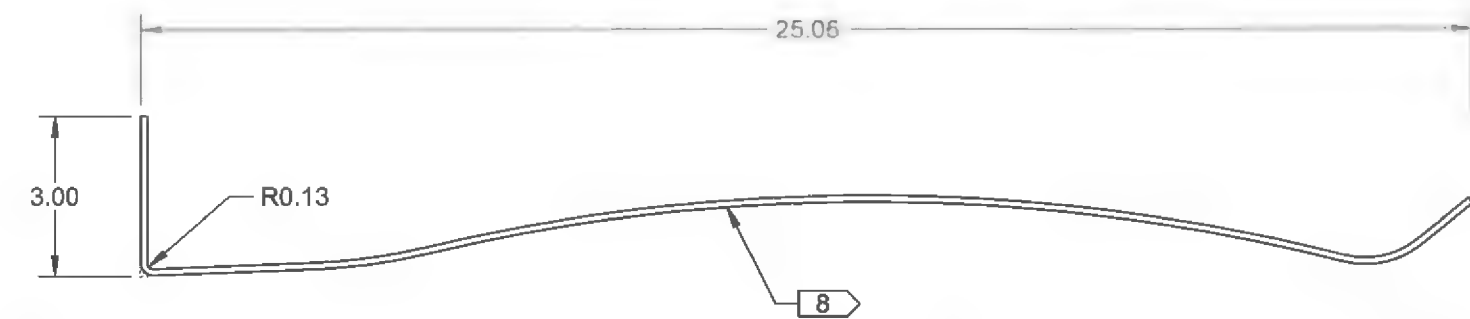
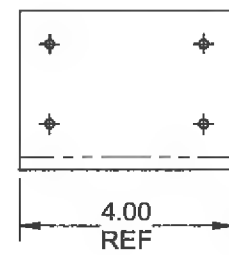


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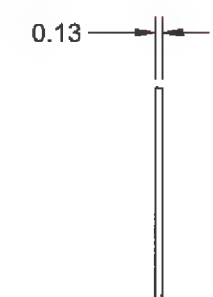
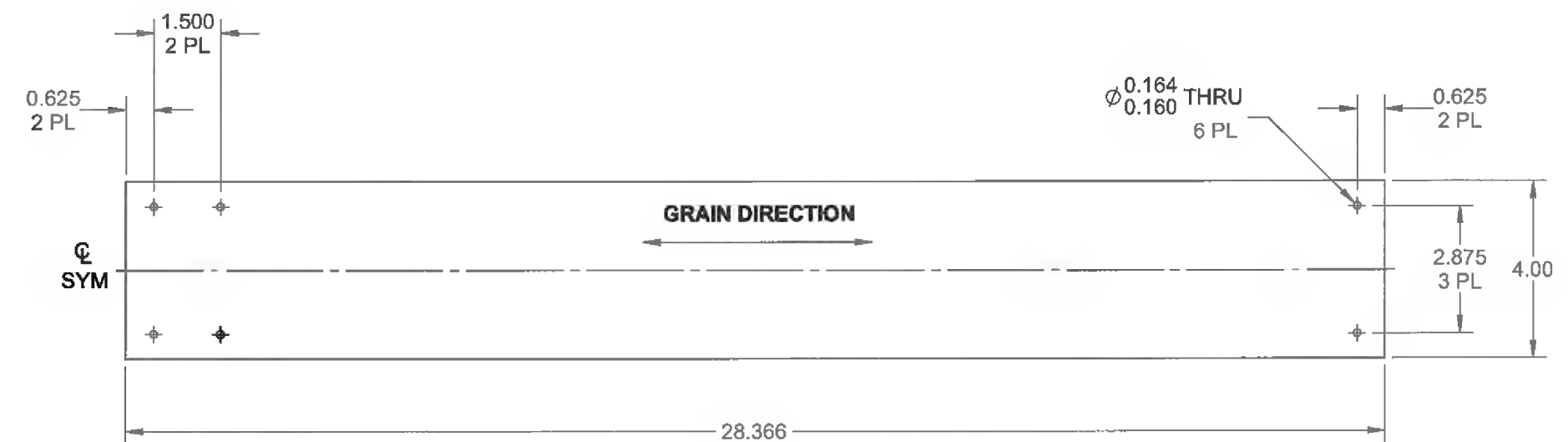


RB 92700-10321-041-M-17 TOP CLAMP PROFILE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
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FLAT PATTERN

- NOTES:
- 1) MATERIAL: A36/1018/1020/1025 HR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) BEND ACCORDING TO PROFILE OF ITEM -16 AT ASSEMBLY

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 21 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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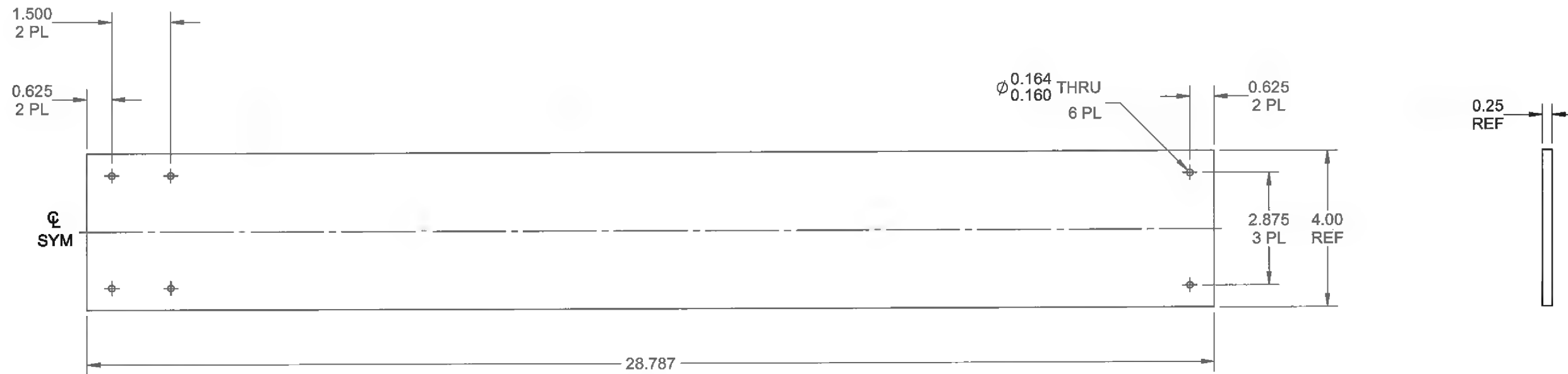
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FLAT PATTERN

RB 92700-10321-041-M-18 TOP CLAMP PROTECTION

PROTOTYPE
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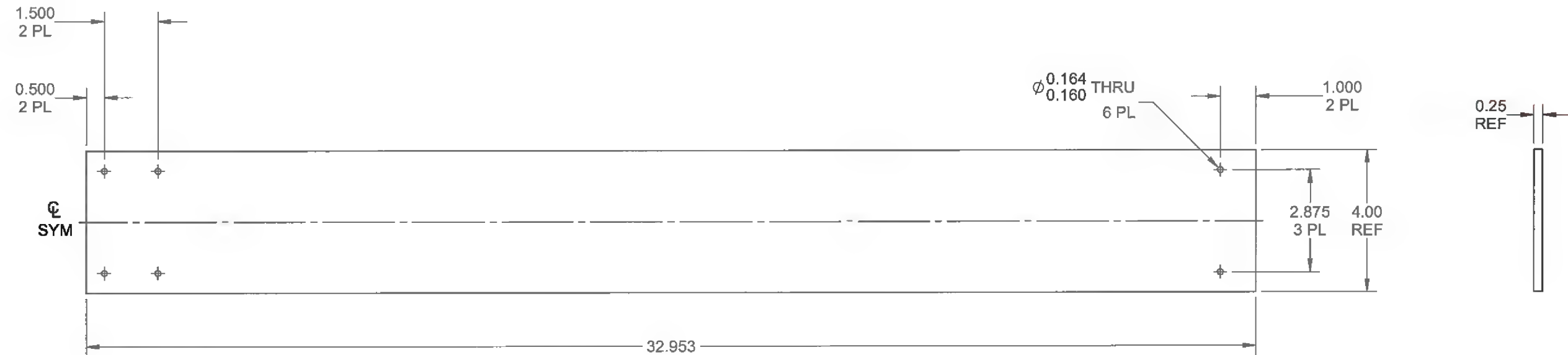
NOTES:
1) MATERIAL: McMaster#3462K16 OR EQUIV.
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 22 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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PROTOTYPE
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DATA TO ENGINEERING
VM



FLAT PATTERN

RB 92700-10321-041-M-19 BOTTOM CLAMP PROTECTION

NOTES:

1) MATERIAL: McMaster#3462K16 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN KPT
DRAWN KPT
CHECKED KPT
MFG. APPR. DP
APPROVED

DATE 2/14/2019

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RB 92700-10321-041-M

TITLE
DUAL CLAMP M/R BLADE SLING

REV. A1

SHEET 23 OF 29

SCALE
NTS

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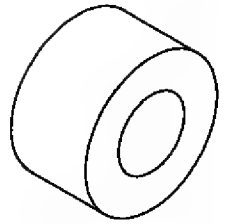
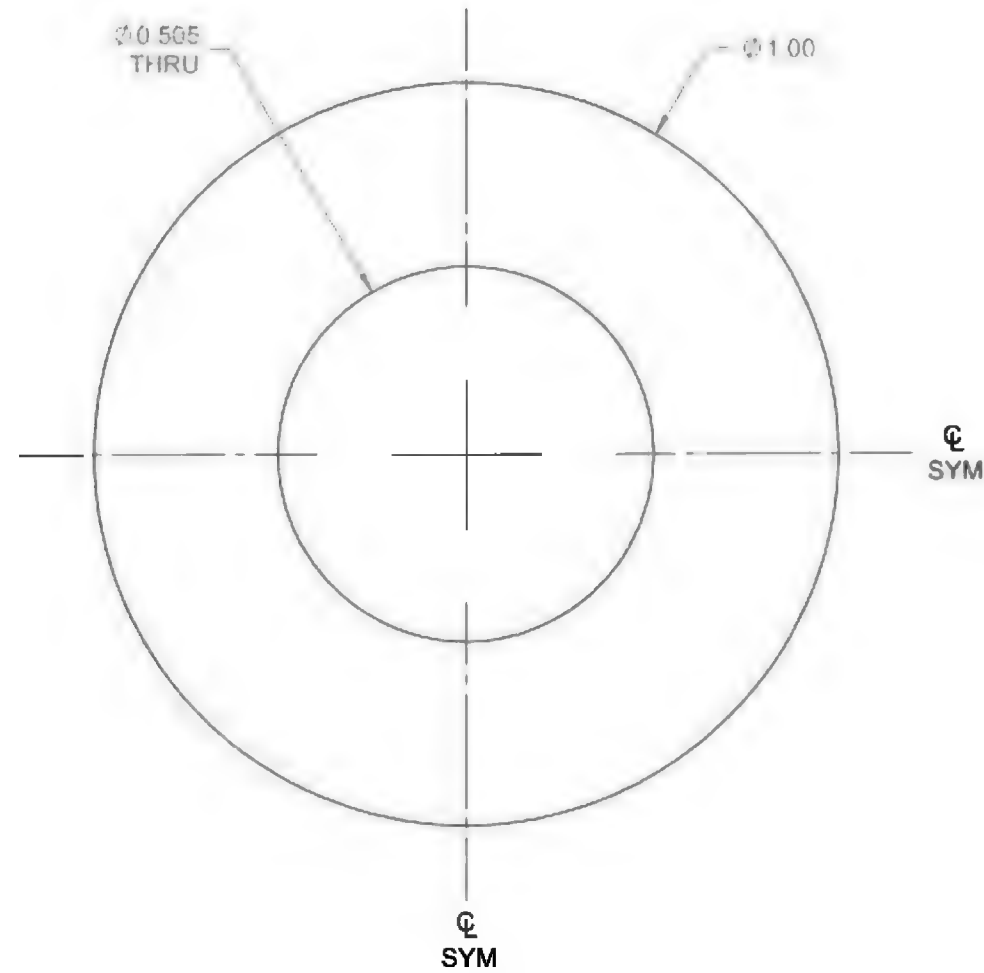
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RB 92700-10321-041-M-20 PULLEY SPACER

PROTOTYPE
PLEASE RETURN ALL ISSUES
DATE 10/10/2019
VH

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED

DATE 2/14/2019

KPT
KPT
KPT
DP

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RB 92700-10321-041-M

REV. A1

TITLE
DUAL CLAMP M/R BLADE SLING

SCALE
NTS

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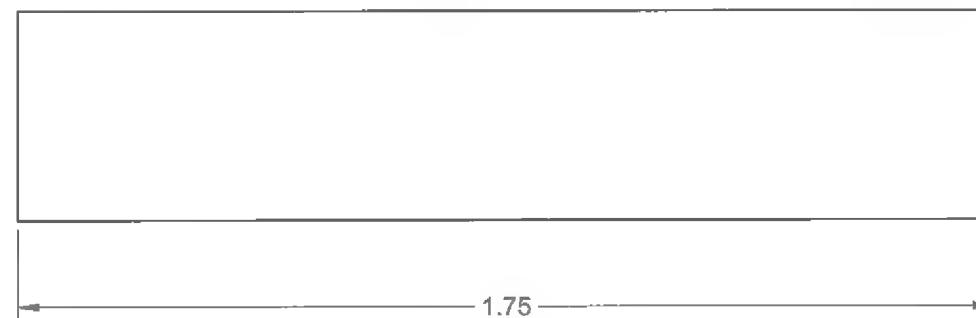
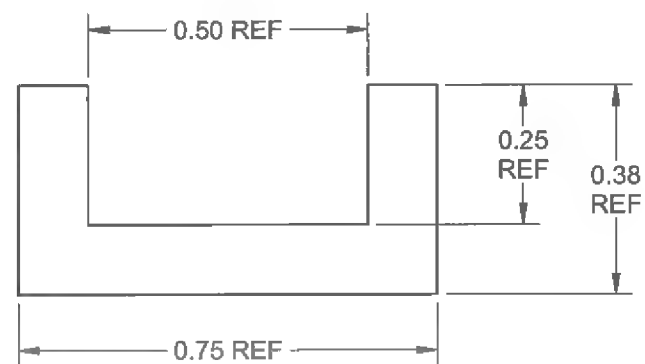
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
VP



RB 92700-10321-041-M-21 TORSION SPRING HOLDER

NOTES:

1) MATERIAL: McMaster#7779T31 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 25 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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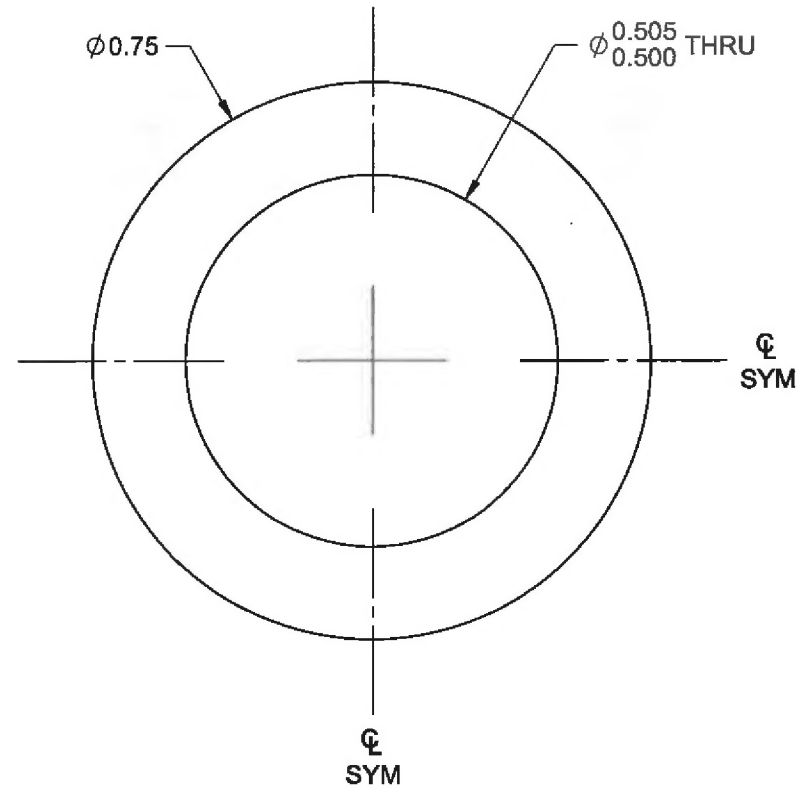
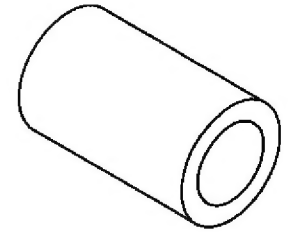
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
VH



RB 92700-10321-041-M-22 TORSION SPRING BUSHING

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 28 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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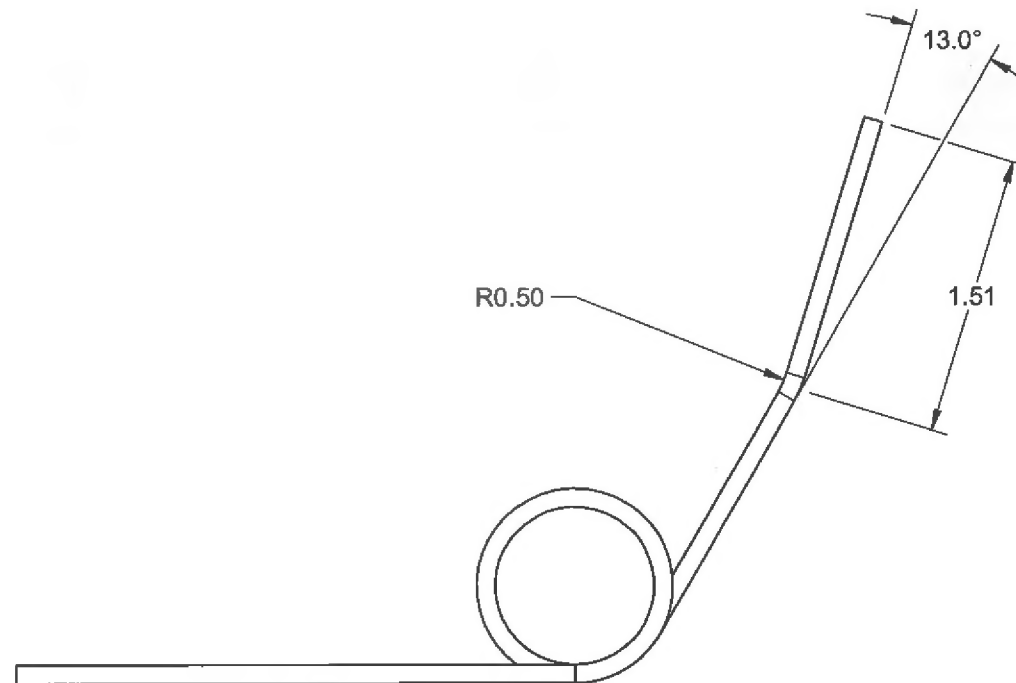
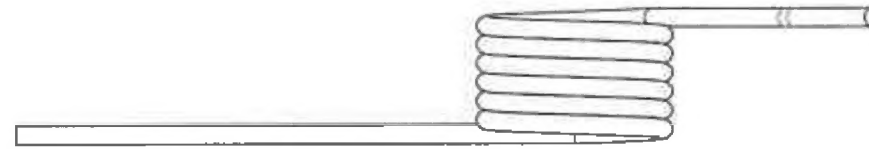
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING



RB 92700-10321-041-M-23 RIGHT HAND TORSION SPRING

NOTES:

1) MATERIAL: McMaster#9271K911 OR EQUIV.

2) HEAT TREAT: N/A


3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD		
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA		
CHECKED	KPT	TOOL PART #		REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M		SHEET 27 OF 29
APPROVED		TITLE		SCALE
		DUAL CLAMP M/R BLADE SLING		NTS 
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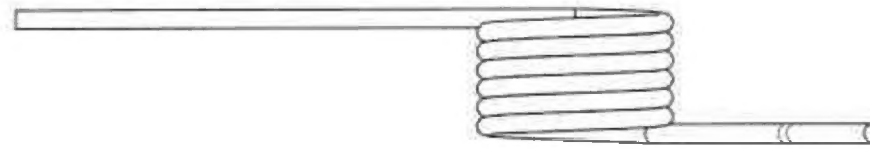
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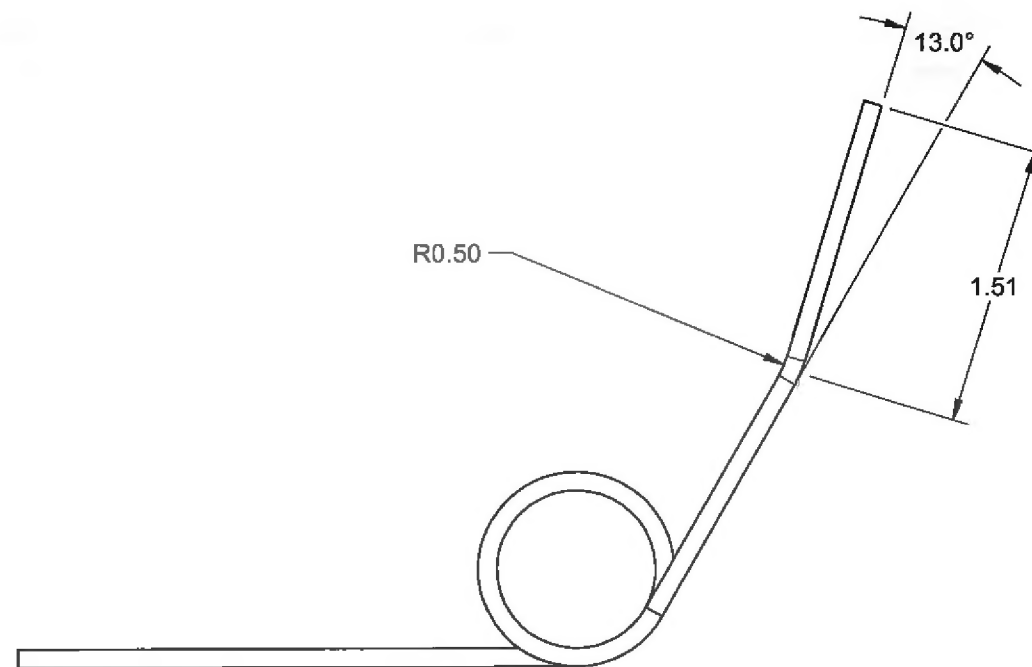
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
VHP



RB 92700-10321-041-M-24 LEFT HAND TORSION SPRING

NOTES:

1) MATERIAL: McMaster#9271K926 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

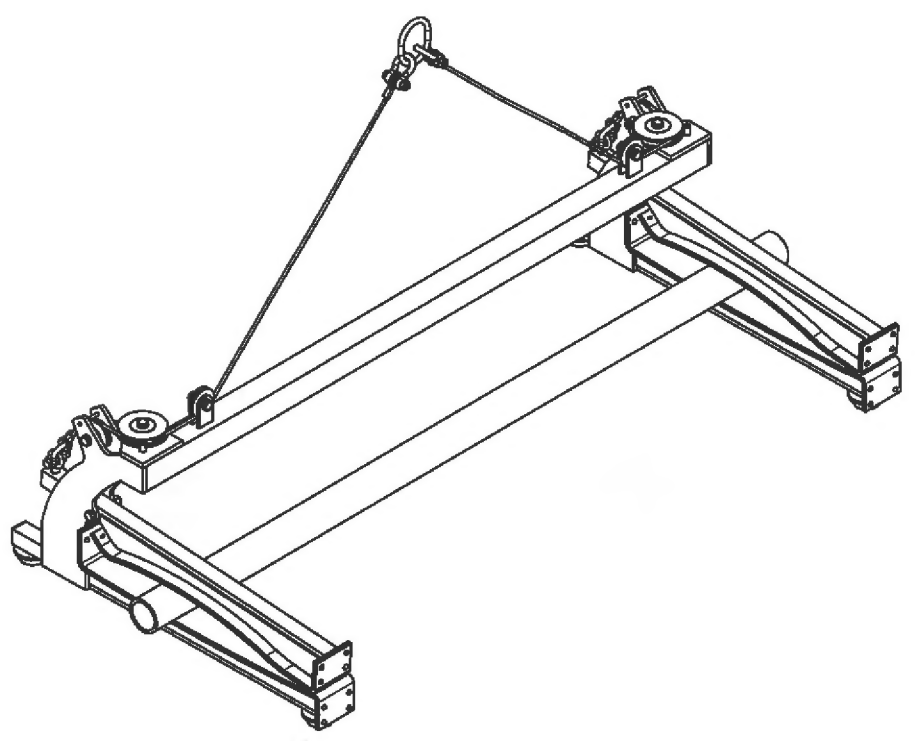
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

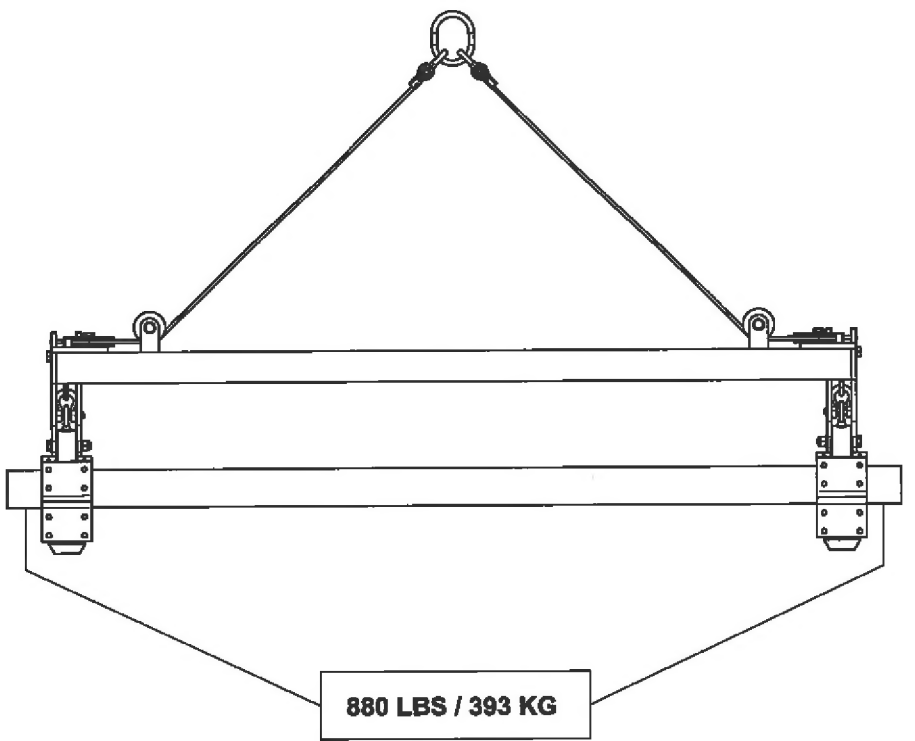
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 28 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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PROTOTYPE
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DATA TO ENGINEERING
VA



FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 880 LBS / 393 KG.
2. LIFT AND MOVE THE SLING ASSEMBLY WITH TEST WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGED/FRAYED STRAPS.
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, DISTORTIONS OR DAMAGED/FRAYED STRAPS.



INSPECTOR: _____
TESTER: _____
S/N: _____
DATE: _____

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A1
MFG. APPR.	DP	RB 92700-10321-041-M	SHEET 29 OF 29
APPROVED		TITLE	SCALE
		DUAL CLAMP M/R BLADE SLING	NTS
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